



16" HORIZONTAL RESAW BANDSAW MODEL G0504 INSTRUCTION MANUAL



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ONLINE MANUAL DISCLAIMER

THE INFORMATION IN THIS MANUAL REPRESENTS THE CONFIGURATION OF THE MACHINE AS IT IS CURRENTLY BEING SHIPPED. THE MACHINE CONFIGURATION CAN CHANGE AS PRODUCT IMPROVEMENTS ARE INCORPORATED. IF YOU OWN AN EARLIER VERSION OF THE MACHINE, THIS MANUAL MAY NOT EXACTLY DEPICT YOUR MACHINE. CONTACT CUSTOMER SERVICE IF YOU HAVE ANY QUESTIONS ABOUT DIFFERENCES. PREVIOUS VERSIONS ARE NOT AVAILABLE ONLINE.

WARNING

Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to the State of California to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks, cement, and other masonry products.
- Arsenic and chromium from chemically treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

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SECTION 1: SAFETY

WARNING

For Your Own Safety, Read Instruction Manual Before Operating this Equipment

The purpose of safety symbols is to attract your attention to possible hazardous conditions. This manual uses a series of symbols and signal words which are intended to convey the level of importance of the safety messages. The progression of symbols is described below. Remember that safety messages by themselves do not eliminate danger and are not a substitute for proper accident prevention measures.



Indicates an imminently hazardous situation which, if not avoided, **WILL** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **COULD** result in death or serious injury.



Indicates a potentially hazardous situation which, if not avoided, **MAY** result in minor or moderate injury. It may also be used to alert against unsafe practices.

NOTICE

This symbol is used to alert the user to useful information about proper operation of the equipment.

WARNING

Safety Instructions for Power Tools

1. **KEEP GUARDS IN PLACE** and in working order.
2. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning on.
3. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
4. **DO NOT USE IN DANGEROUS ENVIRONMENT.** DO NOT use power tools in damp or wet locations, or where any flammable or noxious fumes may exist. Keep work area well lighted.
5. **KEEP CHILDREN AND VISITORS AWAY.** All children and visitors should be kept at a safe distance from work area.
6. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches, or by removing starter keys.
7. **DO NOT FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
8. **USE RIGHT TOOL.** DO NOT force tool or attachment to do a job for which it was not designed.

WARNING

Safety Instructions for Power Tools

- 9. USE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Conductor size should be in accordance with the chart below. The amperage rating should be listed on the motor or tool nameplate. An undersized cord will cause a drop in line voltage resulting in loss of power and overheating. Your extension cord must also contain a ground wire and plug pin. Always repair or replace extension cords if they become damaged.

Minimum Gauge for Extension Cords

AMP RATING	LENGTH		
	25ft	50ft	100ft
0-6	16	16	16
7-10	16	16	14
11-12	16	16	14
13-16	14	12	12
17-20	12	12	10
21-30	10	10	No

- 10. WEAR PROPER APPAREL.** DO NOT wear loose clothing, gloves, neckties, rings, bracelets, or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
- 11. ALWAYS USE SAFETY GLASSES.** Also use face or dust mask if cutting operation is dusty. Everyday eyeglasses only have impact resistant lenses, they are NOT safety glasses.
- 12. SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and frees both hands to operate tool.
- 13. DO NOT OVERREACH.** Keep proper footing and balance at all times.
- 14. MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.

- 15. USE RECOMMENDED ACCESSORIES.** Consult the instruction manual for recommended accessories. The use of improper accessories may cause risk of injury.

- 16. REDUCE THE RISK OF UNINTENTIONAL STARTING.** On machines with magnetic contact starting switches there is a risk of starting if the machine is bumped or jarred. Always disconnect from power source before adjusting or servicing. Make sure switch is in OFF position before reconnecting.

- 17. MANY WOODWORKING TOOLS CAN “KICKBACK” THE WORKPIECE** toward the operator if not handled properly. Know what conditions can create “kickback” and know how to avoid them. Read the manual accompanying the machine thoroughly.

- 18. CHECK DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.

- 19. NEVER LEAVE TOOL RUNNING UNATTENDED. TURN POWER OFF. DO NOT** leave tool until it comes to a complete stop.

- 20. NEVER OPERATE A MACHINE WHEN TIRED, OR UNDER THE INFLUENCE OF DRUGS OR ALCOHOL.** Full mental alertness is required at all times when running a machine.

- 21. NEVER ALLOW UNSUPERVISED OR UNTRAINED PERSONNEL TO OPERATE THE MACHINE.** Make sure any instructions you give in regards to the operation of the machine are approved, correct, safe, and clearly understood.

WARNING

Additional Safety Instructions for Bandsaws

1. **DO NOT OPERATE WITH DULL OR BADLY WORN BLADES.** Dull blades require more demand on the motor and are less likely to cut precisely. Inspect blades before each use.
2. **NEVER POSITION FINGERS OR THUMBS IN LINE WITH THE CUT.** Serious personal injury could occur.
3. **DO NOT OPERATE THIS BANDSAW WITHOUT WHEEL GUARDS, PULLEY GUARDS, AND BLADE GUARDS IN PLACE.**
4. **WHEN REPLACING BLADES,** make sure the teeth face toward the front of the saw.
5. **CUTS SHOULD ALWAYS BE FULLY SUPPORTED** against the side of the conveyor table and by the pressure rollers.
6. **DO NOT BACK WORKPIECE AWAY** from the blade while the saw is running. If you need to back the work out, stop the band-saw and wait for the blade to stop. **DO NOT** twist or put excessive stress on blade while backing work away.
7. **BLADE SHOULD BE RUNNING AT FULL SPEED** before beginning a cut.
8. **ALWAYS FEED STOCK EVENLY AND SMOOTHLY.** **DO NOT** change conveyor speeds during a cut.
9. **THIS MACHINE IS NOT DESIGNED TO CUT METAL** or other material except wood.
10. **DO NOT MANUALLY STOP OR SLOW BLADE** after turning the saw off. Allow it to come to a complete stop before you leave it unattended.
11. **ALL INSPECTIONS, ADJUSTMENTS, AND MAINTENANCE MUST BE DONE WITH THE POWER OFF** and the circuit breaker shut off. Wait for all moving parts to come to a complete stop.
12. **HABITS – GOOD AND BAD – ARE HARD TO BREAK.** Develop good habits in your shop and safety will become second-nature to you.
13. **IF AT ANY TIME YOU ARE EXPERIENCING DIFFICULTIES PERFORMING THE INTENDED OPERATION, STOP USING THE BANDSAW!** Then contact our service department or ask a qualified expert how the operation should be performed.
14. **MAKE SURE BLADE IS PROPERLY TENSIONED BEFORE OPERATING MACHINE.**
15. **KEEP LOOSE CLOTHING AND LONG HAIR AWAY FROM MOVING CONVEYORS!**

WARNING

Like all machines there is danger associated with the Model G0504. Accidents are frequently caused by lack of familiarity or failure to pay attention. Use this machine with respect and caution to lessen the possibility of operator injury. If normal safety precautions are overlooked or ignored, serious personal injury may occur.

CAUTION

No list of safety guidelines can be complete. Every shop environment is different. Always consider safety first, as it applies to your individual working conditions. Use this and other machinery with caution and respect. Failure to do so could result in serious personal injury, damage to equipment, or poor work results.

WARNING

Additional Safety Instructions for Hydraulics

1. BE FAMILIAR WITH THE HAZARDS OF HYDRAULIC INJECTION INJURIES.

- Leaking hydraulic fluid may have enough pressure to penetrate skin. Never use your hands to check for suspected hydraulic leaks.
- Hydraulic fluid that is injected into skin is a medical emergency that may cause infection, disability, amputation or death.
- The average injection injury may be a small wound that has barely broken the skin. DO NOT be fooled by this type of injury. Immediately get to an emergency medical facility!
- Minimizing the time between the injury and when the injected material is removed is critical to minimizing the seriousness of the injury.

2. USE A PIECE OF CARDBOARD TO CHECK FOR SUSPECTED HYDRAULIC LEAKS.

Pressurized hydraulic fluid may cause injection injuries and can be extremely hot. Never use your hands to check for suspected hydraulic leaks.

3. PROTECT YOUR EYES AROUND HYDRAULIC SYSTEMS.

Safety glasses may not always protect your eyes from hot, pressurized fluid. The best way to protect yourself is to stay away from leaks until you can depressurize the system.

4. STOP THE MACHINE IF YOU NOTICE A HYDRAULIC LEAK.

Allowing the machine to continue running with a leak may increase the hazard of the situation.

5. DEPRESSURIZE THE HYDRAULIC SYSTEM BEFORE ATTEMPTING TO ADJUST ANY HYDRAULIC LINES OR FITTINGS.

Stop the resaw, open the conveyor speed valves, and make sure the pressure gauge reads 0 PSI.

6. DEPRESSURIZE THE HYDRAULIC SYSTEM BEFORE ATTEMPTING ANY MAINTENANCE OR SERVICE.

Stop the resaw, open the conveyor speed valves, and make sure the pressure gauge reads 0 PSI.

7. REGULARLY INSPECT AND PERFORM THE PROPER MAINTENANCE ON THE HYDRAULIC SYSTEM.

A well-maintained hydraulic system will have much fewer problems and hazards than a neglected system.

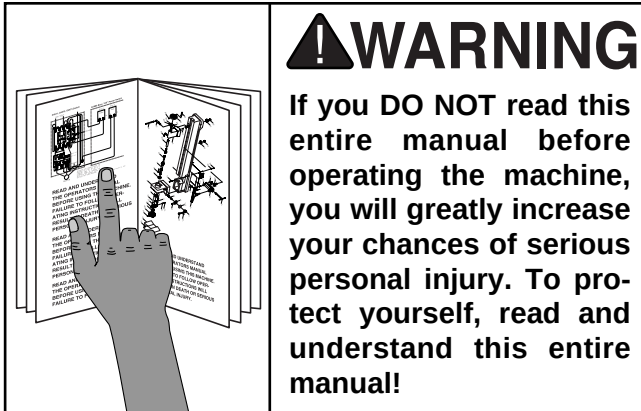
8. MAKE SURE ANY HYDRAULIC SYSTEM MAINTENANCE IS PERFORMED IN A CLEAN AND DUST-FREE WORK AREA.

Remove any sawdust, grime or water from hydraulic system openings or components before maintenance. Always use lint-free rags when wiping components.

9. ONLY USE HIGH PRESSURE HYDRAULIC HOSE AND STEEL HYDRAULIC FITTINGS WHEN REPLACING COMPONENTS IN THE HYDRAULIC SYSTEM.

DO NOT use brass or aluminum.

SECTION 2: GENERAL INFORMATION



Commentary

Grizzly Industrial, Inc. is proud to offer the Model G0504 16" Horizontal Resaw Bandsaw. This resaw bandsaw is part of Grizzly's growing family of fine woodworking machinery. When used according to the guidelines stated in this manual, you can expect years of trouble-free, enjoyable operation, and proof of Grizzly's commitment to customer satisfaction.

We are also pleased to provide this manual for the Model G0504. It was written to guide you through assembly, review safety considerations, and cover general operating procedures. It represents our latest effort to produce the best documentation possible.

If you have any comments or criticisms that you feel we should address in our next printing, please write to us at:

Grizzly Industrial, Inc.
% Technical Documentation
P.O. Box 2069
Bellingham, WA 98227

Most important, we stand behind our machines. We have excellent regional service departments at your disposal should the need arise.

If you have any service questions or parts requests, please call or write to us at the location listed below.

Grizzly Industrial, Inc
1203 Lycoming Mall Circle
Muncy, PA 17756
Phone:(570) 546-9663
Fax:(800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>

The specifications, drawings, and photographs illustrated in this manual represent the Model G0504 as supplied when the manual was prepared. However, owing to Grizzly's policy of continuous improvement, changes may be made at any time with no obligation on the part of Grizzly. For your convenience, we always keep current Grizzly manuals available on our website at www.grizzly.com. Any updates to your machine will be reflected in these manuals as soon as they are complete.



SECTION 3: CIRCUIT REQUIREMENTS

220V 3-Phase

WARNING

Serious personal injury could occur if you connect your machine to the power source before you have completed the setup process. **DO NOT** connect the machine to the power source until instructed to do so.

Wiring

The Model G0504 is prewired for 220V operation.

Amperage Draw

The Model G0504 has a 25 HP main motor and a ¼ HP elevation motor that will draw the following amps at 3-phase 220V:

Main Motor	60 Amps
Elevation Motor	1.5 Amps

Circuit Breaker Requirements

Install your bandsaw on a dedicated circuit to reduce the possibility of overloading the circuit and tripping the circuit breaker. If the circuit breaker trips and the circuit is of the correct load capacity, have the circuit inspected by qualified electrician. Never use a larger circuit breaker than stated below, or you will increase the risk of fire.

Circuit Breaker	70 Amp
-----------------------	--------

Minimum Cord Requirements

For 220V 3-phase operation, use the following type of cord:

Cord.....	3 pole, 4 wire
Gauge	4

Connection Type

Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking shut-off lever (see **Figure 1**) near the machine as a way to quickly disconnect the power. We **DO NOT** recommend using an extension cord with this machine.

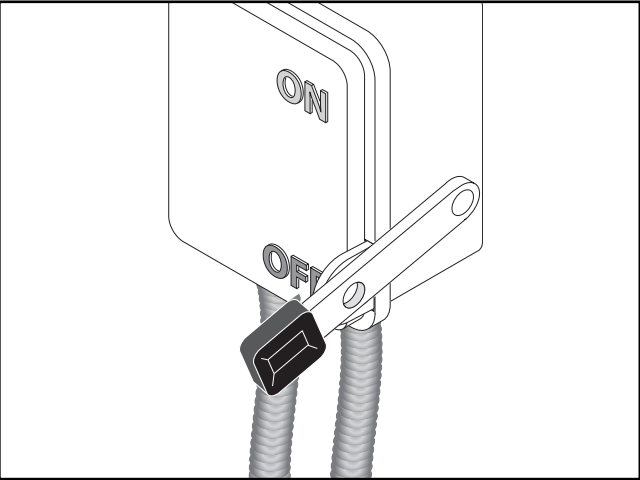


Figure 1. A power disconnect is preferable to high current plugs and receptacles.

Your Shop Circuit Capacity

Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

CAUTION

A fire may occur if your particular electrical configuration does not comply with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician.



440V 3-Phase

WARNING

Serious personal injury could occur if you connect your machine to the power source before you have completed the setup process. **DO NOT** connect the machine to the power source until instructed to do so.

Wiring

The Model G0504 is prewired for 220V 3-phase, but can be rewired to 440V operation. If you decide to rewire the Model G0504 to 440V, you must follow the instructions on **pages 10-11** that are titled "Converting to 440V."

Amperage Draw

The Model G0504 has a 25 HP 3-phase main motor and a 1/4 HP 3-phase elevation motor that will draw the following amps at 440V:

Main Motor	30 Amps
Elevation Motor	0.75 Amps

Circuit Breaker Requirements

Install your bandsaw on a dedicated circuit to reduce the possibility of overloading the circuit and tripping the circuit breaker. If the circuit breaker trips and the circuit is of the correct load capacity, have the circuit inspected by qualified electrician. Never use a larger circuit breaker than is stated below, or you will increase the risk of fire.

Circuit Breaker	40 Amp
-----------------------	--------

Minimum Cord Requirements

For 440V operation, use the following type of cord:

Cord.....	3 pole, 4 wire
Gauge	8

Connection Type

Because of the high amperage draw from this machine, we recommend that you hardwire it directly to your circuit breaker and install a locking shut-off lever (see **Figure 2**) near the machine as a way to quickly disconnect the power. We **DO NOT** recommend using an extension cord with this machine.

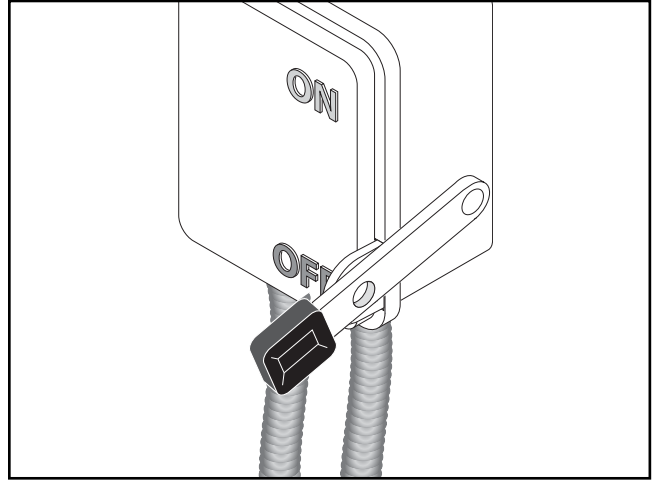


Figure 2. A power disconnect is preferable to high current plugs and receptacles.

Your Shop Circuit Capacity

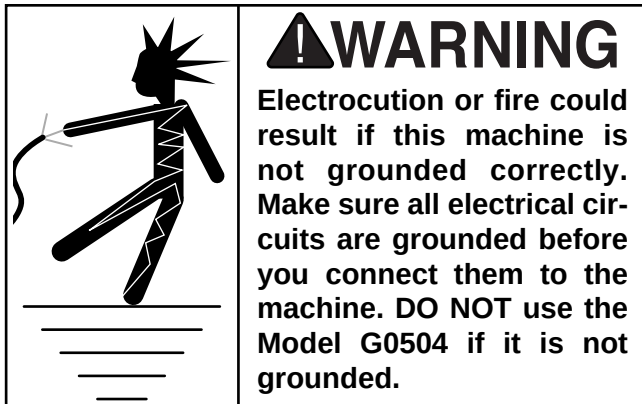
Always check to see if the wires in your circuit are capable of handling the amperage draw from your machine, as well as any other machines that could be operating on the same circuit. If you are unsure, consult a qualified electrician.

CAUTION

A fire may occur if your particular electrical configuration does not comply with local and state codes. The best way to ensure compliance is to check with your local municipality or a licensed electrician.



Grounding



In the event of an electrical malfunction or breakdown, grounding provides a path of least resistance for electric current to reduce the risk of electric shock. This machine must be equipped with an electric cord that has an equipment grounding conductor. This conductor must be grounded in accordance with all local codes and ordinances.

Improper connections of the electrical-grounding conductor can result in the risk of electric shock. Check with a qualified electrician or one of our service personnel if the grounding instructions are not completely understood, or if you are in doubt as to whether the machine is properly grounded.



Extension Cords

Because of the high amperage draw from this machine, we do not recommend the use of extension cords. Instead, position your equipment near installed wiring to eliminate the need for extension cords.



Converting to 440V

Converting the Model G0504 to 440V operation consists of 1) wiring the voltage transformer, 2) rewiring the main motor and the elevation motor, and 3) changing the main over-load relay with the relay included in the Grizzly Model G0504, 440V Conversion Kit (item #P0504919).

To convert the Model G0504 to 440V:

1. Disconnect the resaw from the power source!
2. Open the electrical box and locate the voltage transformer and the fuse terminals shown in **Figure 3**.

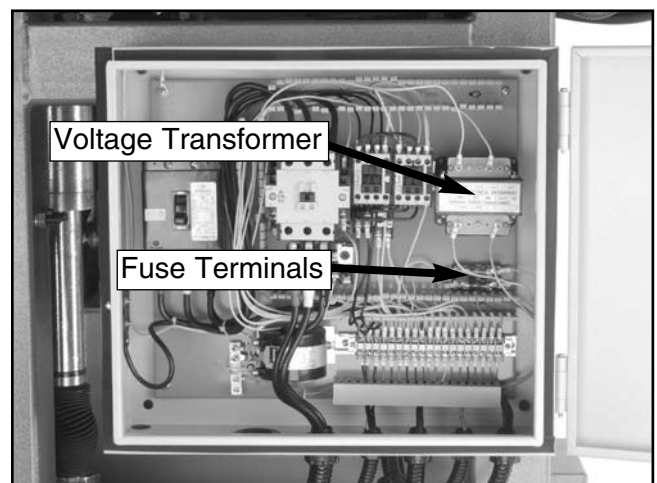


Figure 3. Inside of electrical box.

3. Remove the T and R wires from the fuse terminals and connect them to the terminals on the upper part of the voltage transformer, at the location shown in **Figure 4**; then attach the wires included with 440V conversion kit from the fuse terminals to the terminals on the lower part of the voltage transformer, also as shown in **Figure 4**. Note—*Make sure the wires are routed through the wiring duct to properly secure them and minimize fire hazards.*

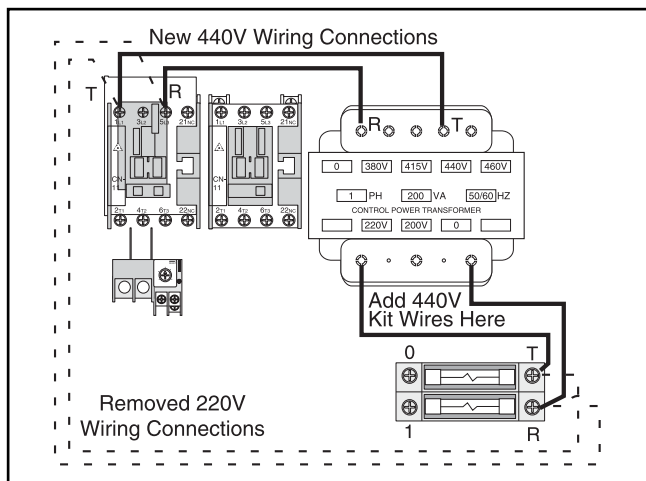


Figure 4. Wiring connections for 440V conversion.

4. Remove the wiring caps on the main and elevation motors.
5. Wire the main and elevation motors as shown on the diagrams on the inside of each motor wire cover. Note—*The circled references on the diagrams represent labels on the wires.* Also, **Figures 5 & 6** below have been provided for your reference and are current at the time that this manual was written. However, always use the diagram on the wire cover that comes with your motor!

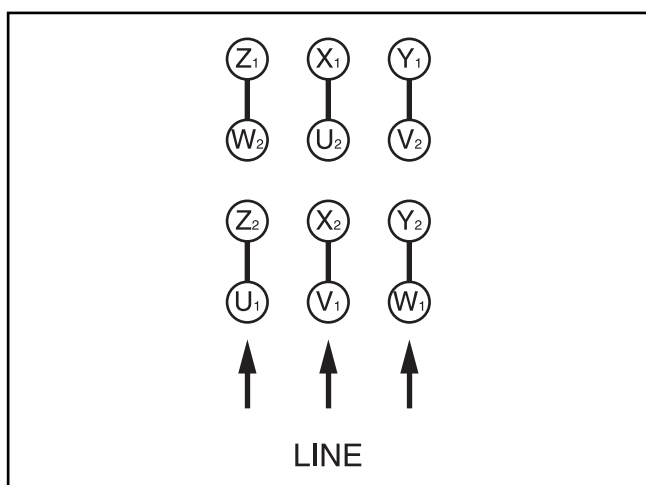


Figure 5. Main motor 440V wiring.

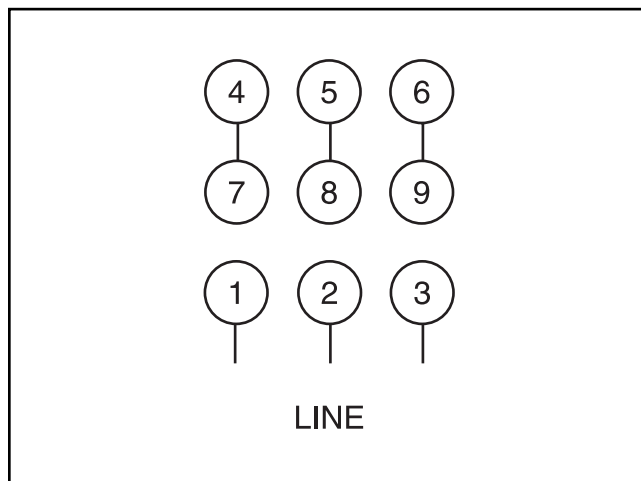


Figure 6. Elevation motor 440V wiring.

6. Replace the main relay (RH-65/55A) with the relay from kit (RH-35/30A) and set the dial to “31.”
7. Replace any wire duct covers and motor caps you might have removed during this procedure, and close the electrical box door.
8. Call a licensed electrician to inspect your work before test running the machine.

⚠ CAUTION

A fire may occur if your conversion job does not comply with local and state codes. Ensure your wiring conversion is inspected and approved by a licensed electrician before connecting your machine to the power source.



SECTION 4: MACHINE FEATURES

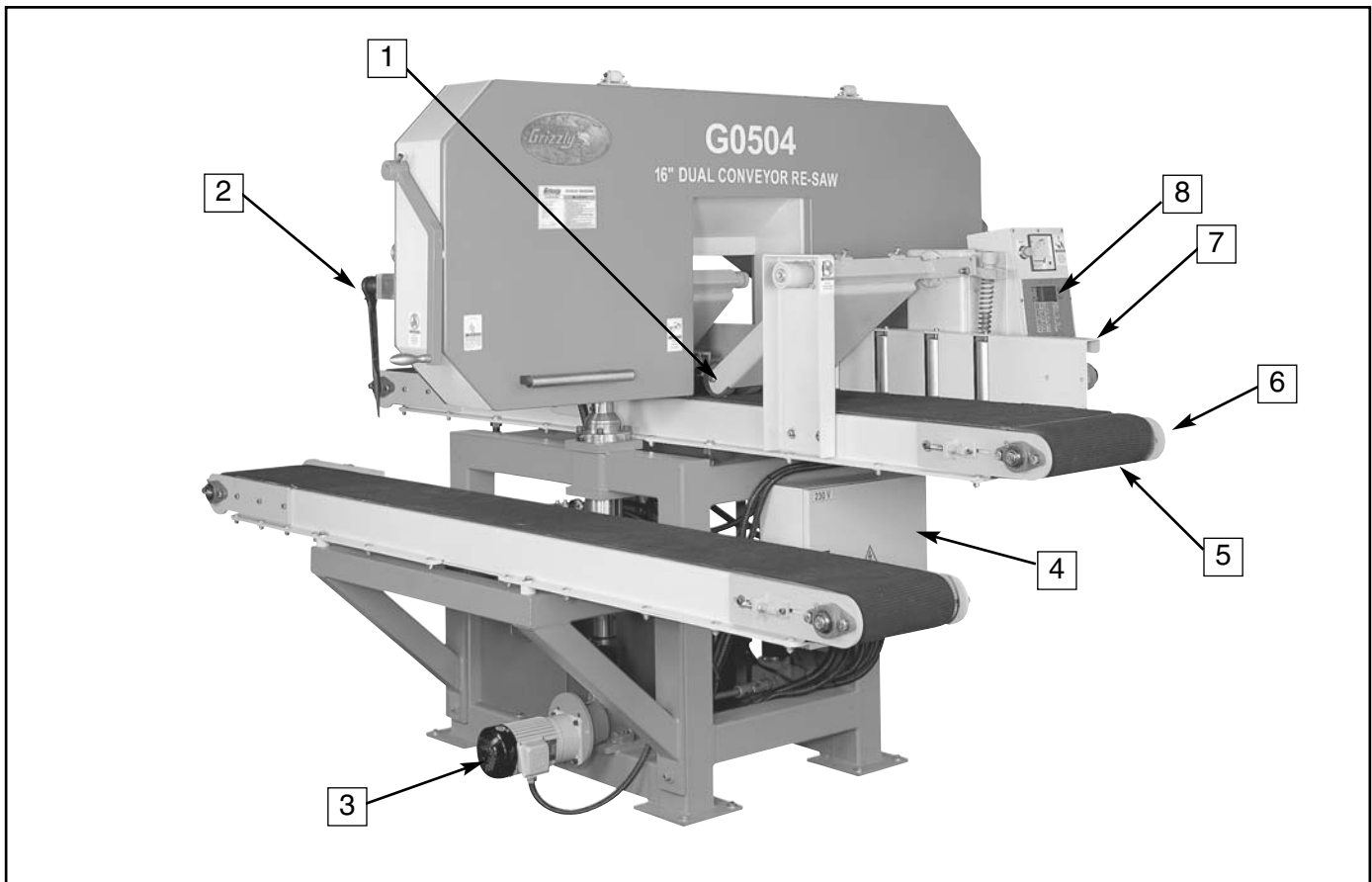


Figure 7. Main view of machine features and controls.

Main Features

1. **Infeed Pressure Rollers**—Maintain downward pressure on the board to keep it sturdy during cutting.
2. **Blade Tensioner**—Provides a mechanical means for properly tightening the blade.
3. **Head Elevation Motor**—Responsible for moving the head (the part of the saw that contains the wheels and blade) up or down as needed.
4. **Electrical Control Box**—Main area for wiring, rewiring, and changing the fuses. Should never be opened when the machine is connected to the power source!
5. **Infeed Conveyor**—Moves the board through the bandsaw blade during cutting.
6. **Infeed Conveyor Speed Dial**—Controls the conveyor belt feed rate.
7. **Infeed Conveyor Engagement Lever**—Allows the operator to stop and start the infeed conveyor while the blade is moving.
8. **Control Panel**—The part of the resaw where the operator can control the starting and stopping of the motor, the various height changes, and the calibration of the blade height to the conveyor. The control panel also houses a load meter that allows the operator to monitor the load being placed on the resaw during operation. For more details, see [page 14](#).

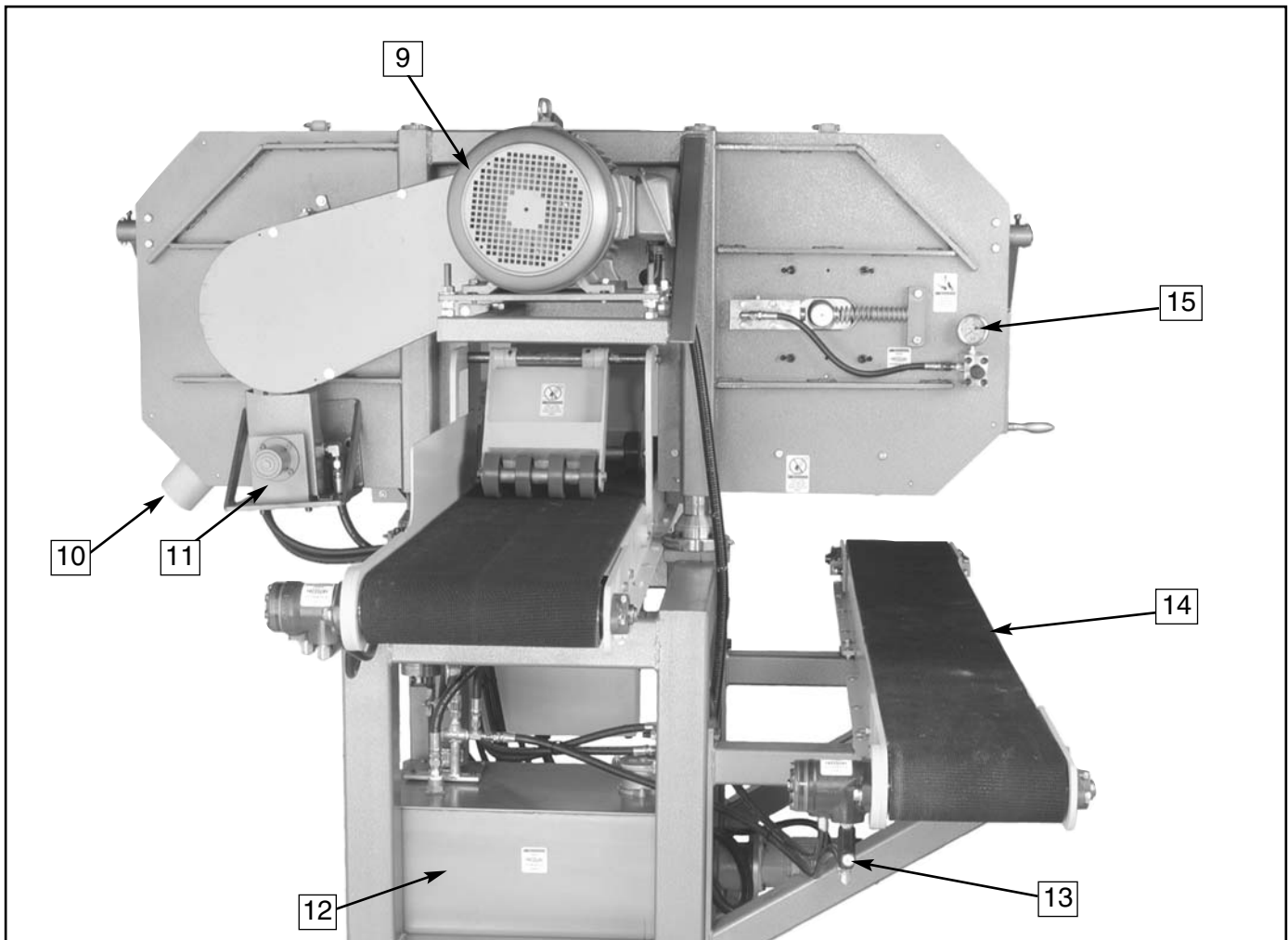


Figure 8. Main view of machine features and controls.

- 9. Main Motor**—Powers the saw wheels for blade movement and drives the hydraulic pump for conveyor movement.
- 10. 4" Dust Port**—Allows the resaw to be connected to a dust collection system.
- 11. Hydraulic Pump**—Creates hydraulic oil flow which drives the conveyor motors.
- 12. Hydraulic Tank**—Holds and cools the hydraulic fluid for the hydraulic system.

- 13. Return Conveyor Speed Dial**—Controls the speed that the return conveyor belt moves.
- 14. Return Conveyor**—Allows the person receiving the newly cut board to return it to the operator without walking around the saw.
- 15. Blade Tension Gauge**—Shows the current blade tension.



Control Panel

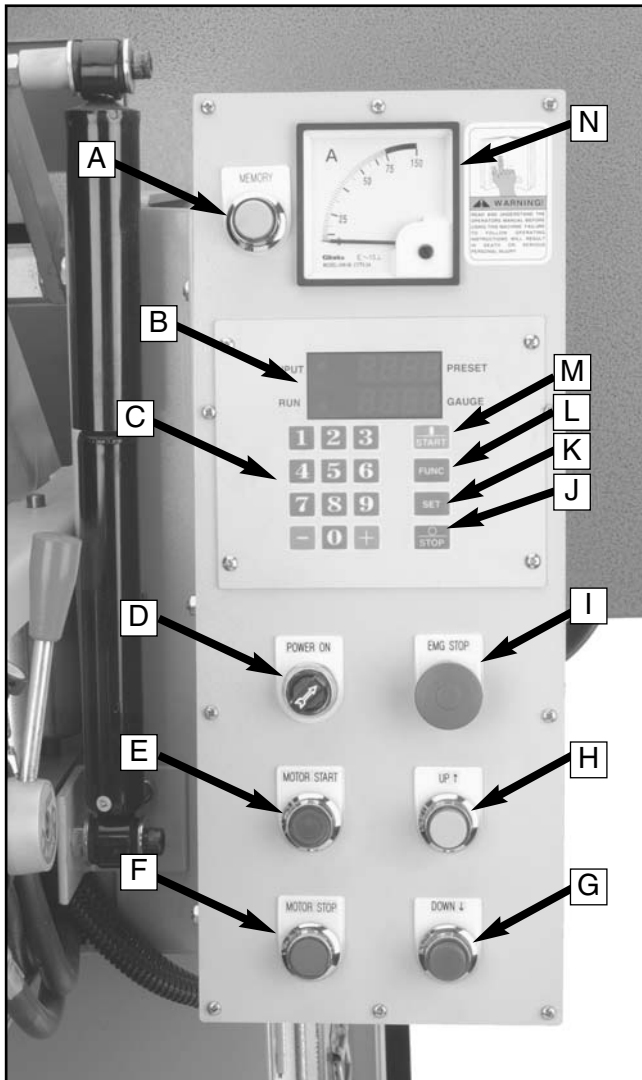


Figure 9. Control panel close-up.

- A. Memory Button**—Moves blade to a preset height change. For example, if you want to produce multiple $\frac{1}{4}$ " boards from a 5" board, you can set the memory to X inches ($X = \frac{1}{4}" +$ your blade kerf). After every cut, the head will automatically move down X inches when you press the memory button. You can then repeat this procedure until the 5" board is reduced to the last $\frac{1}{4}$ " that can be cut from that board.
- B. Display**—Shows the distance from the conveyor belt to the blade. Also used to enter and change settings, move blade height, and program the memory function.

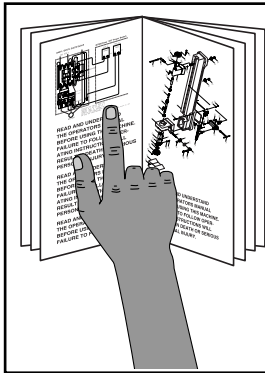
- C. Keypad**—Inputs height values.
- D. POWER ON Switch**—Engages power to the control panel.
- E. MOTOR START Button**—Starts the main motor, which is responsible for the blade and conveyor movement.
- F. MOTOR STOP Button**—Stops the main motor, blade, and conveyors.
- G. DOWN Button**—Moves the head (blade) down toward the infeed conveyor.
- H. UP Button**—Moves the head (blade) up toward the infeed conveyor.
- I. EMG STOP Button**—Cuts power to the main motor to stop the blade and hydraulic pump. (*Caution—It takes approximately 30 seconds for the blade to come to a complete stop.*)
- J. STOP Key**—Stops the elevation motor from its current movement.
- K. SET Key**—Calibrates the height of the blade from the table, or can be used in combination with the *FUNC* key to set the memory.
- L. FUNC Key**—Prepares the control panel for special functions. Can be used in combination with the *START* key to manually type in a numeric height on the keypad, or can be used in combination with the *SET* key to set the memory.
- M. START Key**—Moves the blade to the height that is entered in the keypad. Must be used in conjunction with the *FUNC* key.
- N. Load Meter**—Displays the current load placed on the machine. The load meter is used to determine the appropriate conveyor feed rate for each species of wood and each blade being used.



SECTION 5: SET UP

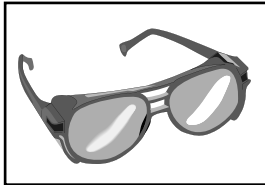
About this Section

The purpose of this section is to guide you through the required steps to get your machine out of its crate and into operating condition.



!WARNING

This machine presents serious injury hazards to untrained users. Read through this entire manual to become familiar with the controls and operations before starting the machine!



!WARNING

Wear safety glasses during the entire set up process!



Unpacking

The Model G0504 is shipped from the manufacturer in a carefully built crate. If you discover the machine is damaged after you have signed for delivery, *please immediately call Customer Service at (570) 546-9663 for advice.*

Save the containers and all packing materials for possible inspection by the carrier or its agent. *Otherwise, filing a freight claim can be difficult.*

When you are completely satisfied with the condition of your shipment, you should inventory the equipment from the shipping crate.



Piece Inventory

After all the parts have been removed from the shipping crate, you should have:

- Resaw Bandsaw Machine
- Bandsaw Blade 180" x 1" x 0.035"
- Tool Box
- 10 Ton Hand Press Pump
- 7 pc. Combination Wrench Set
—10, 12, 13, 14, 17, 19, 21 mm
- 7 pc. Hex Wrench Set
—2.5, 3, 4, 5, 6, 8, 10 mm
- Phillips Head Screwdriver
- Flat Head Screwdriver
- Blade Tensioning Ratchet 21, 23 mm
- Adjustment Wrench 32 mm
- Wheel Cover Handle
- Spare Parts Hardware Bag
 - Cap Screw (4) M10-1.25 x 30
 - Cap Screw (4) M10-1.25 x 25
 - Hex Bolt (4) M12-1.5 x 40
 - Hex Nut (4) M12-1.5

In the event that any non-proprietary parts are missing (e.g. nuts or washers), we would be glad to replace them, or for the sake of expediency, replacements can be obtained at your local hardware store.

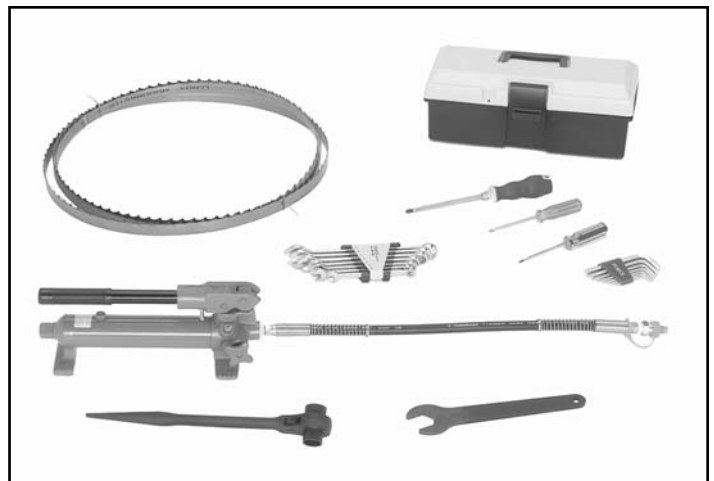


Figure 10. Piece inventory from packing crate.

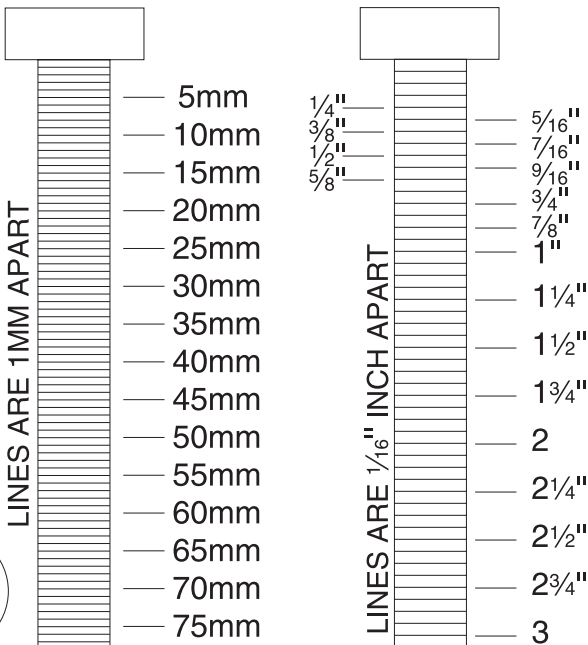
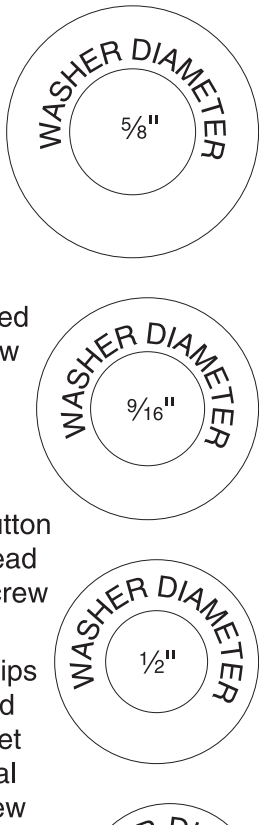
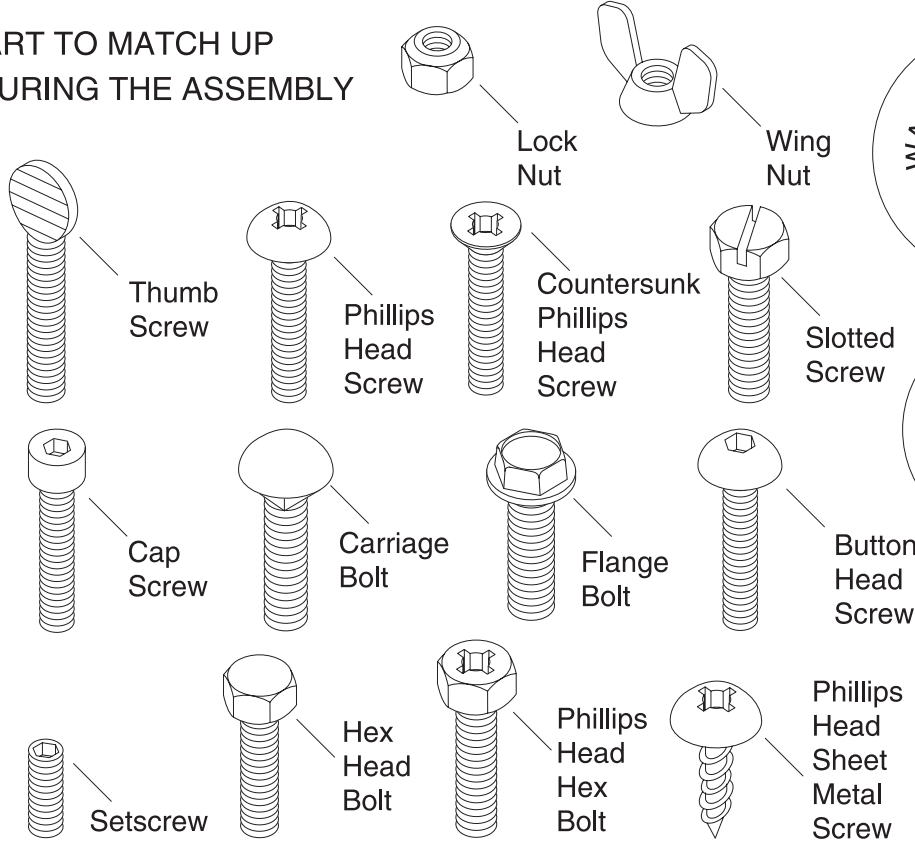


Hardware Recognition Chart

USE THIS CHART TO MATCH UP
HARDWARE DURING THE ASSEMBLY
PROCESS!

MEASURE BOLT DIAMETER BY PLACING INSIDE CIRCLE

- #10
- 1/4"
- 5/16"
- 3/8"
- 7/16"
- 1/2"
- 5/8"



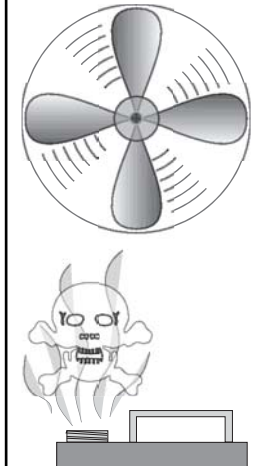
WASHERS ARE MEASURED BY THE INSIDE DIAMETER

Clean Up

The unpainted surfaces are coated with a waxy oil to protect them from corrosion during shipment. Remove this protective coating with a solvent cleaner or citrus-based degreaser such as Grizzly's G7895 Degreaser. To clean thoroughly, some parts may need to be removed. **For optimum performance from your machine, make sure you clean all moving parts or sliding contact surfaces that are coated.** Avoid chlorine-based solvents as they may damage painted surfaces should they come in contact. Always follow the manufacturer's instructions when using any type of cleaning product.

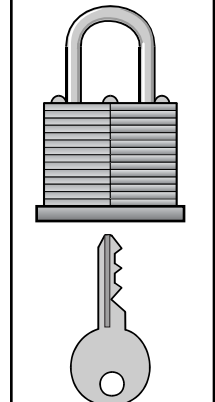
	! WARNING Gasoline and petroleum products have low flash points and could cause an explosion or fire if used to clean machinery. DO NOT use gasoline or petroleum products to clean the machinery.
--	---

	! WARNING Smoking near solvents could ignite an explosion or fire and cause serious injury. DO NOT smoke while using solvents.
---	---

	! CAUTION Many of the solvents commonly used to clean machinery can be toxic when inhaled or ingested. Lack of ventilation while using these solvents could cause serious personal health risks or fire. Take precautions from this hazard by only using cleaning solvents in a well ventilated area.
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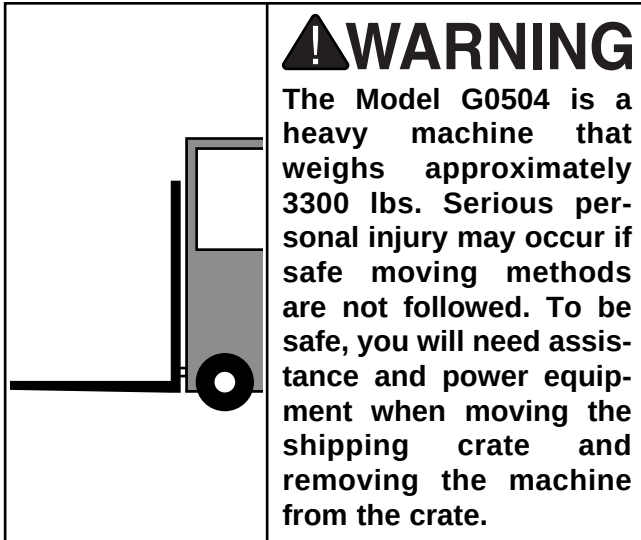
Site Considerations

1. **Floor Load:** The Model G0504 represents a large weight load (3300 lbs.) in a large footprint. Most commercial floors are suitable for your machine. Some residential floors may require additional build up to support both the machine and operator.
2. **Working Clearances:** Consider existing and anticipated needs, size of material to be processed through each machine, and space for auxiliary stands, work tables or other machinery when establishing a location for your bandsaw.
3. **Lighting and Outlets:** Lighting should be bright enough to eliminate shadow and prevent eye strain. Electrical circuits should be dedicated or large enough to handle amperage requirements. Outlets should be located near each machine so power or extension cords are clear of high-traffic areas. Observe local electrical codes for proper installation of new lighting, outlets, or circuits.

	! CAUTION Unsupervised children and visitors inside your shop could cause serious personal injury to themselves. Lock all entrances to the shop when you are away and DO NOT allow unsupervised children or visitors in your shop at any time!
--	---



Removing Resaw from Crate Pallet



To remove the resaw from the crate pallet:

1. Remove the lag bolts from the stand feet that secure the resaw to the crate pallet.
2. Using a wrench, remove the pressure gauge that is located on top of the hydraulic reservoir as shown in **Figure 11**. Note—*This step is optional, but highly recommended to avoid damaging the pressure gauge. If you do this step, plug the opening on both the fitting and the gauge to keep contamination out of the hydraulic system.*



Figure 11. Removing pressure gauge.

3. Using a forklift, lift the resaw from the frame location shown in **Figure 12**, and move it to your predetermined location.

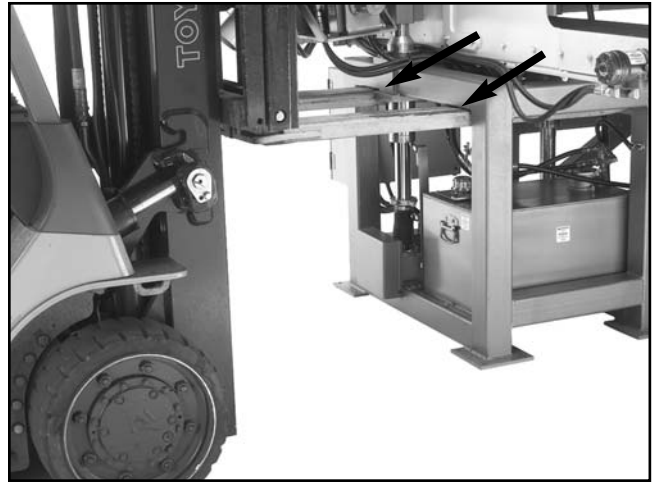


Figure 12. Lifting points for moving the resaw with a forklift.

4. After placing the resaw, make sure that you remove any plugs and replace the hydraulic pressure gauge before continuing to the next step!



Mounting Resaw to the Floor

Although not required, we recommend that you mount your new resaw machine to the floor. Because this is an optional step and floor materials may vary, floor mounting hardware is not included.

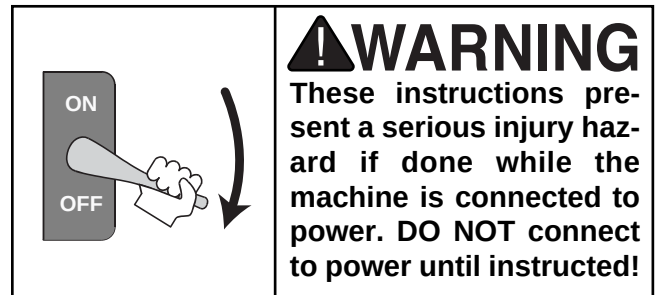
Note—The instructions below are given for a typical heavy-duty shop floor made of 6" thick concrete. Also, anchor studs may be substituted for lag bolts, but they will stick out of the floor if you decide to move your machine at a later point.

To mount the resaw machine to the floor:

1. For these steps you will need:
 - Hammer drill
 - ½" punch
 - ½" hammer drill bit that is at least 6" long
 - Twelve (12) ⅝" x 3" lag shields
 - Twelve (12) ⅝" x 4" lag bolts
 - Twelve (12) ⅝" extra-wide flat washers
 - Hammer
2. Put on safety glasses and a dust mask before starting!
3. Use the mounting holes in the resaw stand feet to act as a guide for drilling into your floor, and drill approximately 3½" deep into the concrete floor.
4. Using compressed air and a vacuum hose, remove the concrete dust from the newly drilled holes.
5. Using the hammer and punch, pound the lag shields into the concrete below the stand feet and flush with the surface of the concrete.
6. Secure the resaw to the floor with the ⅝" lag bolts and washers.



Installing & Tensioning Blade



Blade installation can be done by one person but is easiest if done with two people.

To install the blade:

1. Put on safety glasses and heavy leather gloves.
2. Open the wheel cover to gain access to the wheels.
3. Hold the blade from each side, and position it in front of the wheels so the blade teeth are facing the front of the machine, as shown in **Figure 13**.

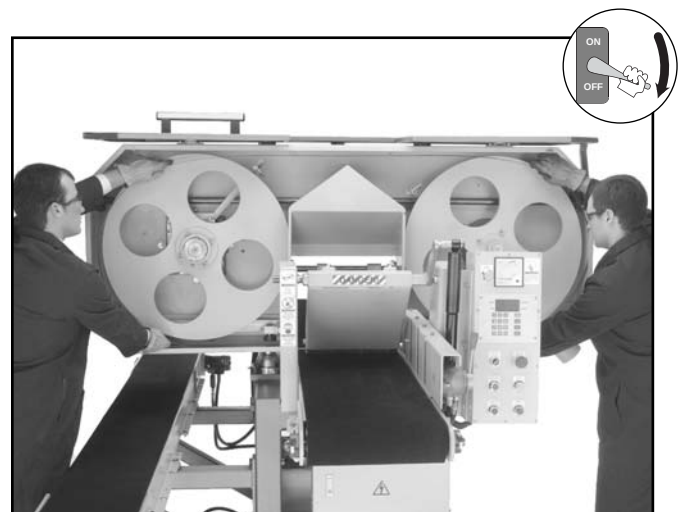


Figure 13. Positioning blade for installation.

4. Carefully fit the blade over each wheel, and position it between the blade guides as shown in **Figure 14**. Make sure the teeth point toward the right-hand side of the machine, as you are facing the front.

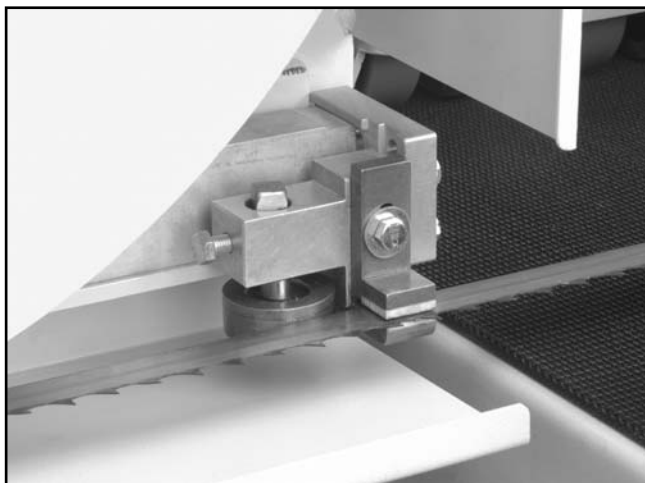


Figure 14. Blade positioned between blade guides.

5. Position the blade on the wheels so that the tooth gullet is approximately $\frac{1}{16}$ " over the edge of the wheel, as shown in **Figure 15**. Also, see the blade illustration in **Figure 16** for more details about this concept.



Figure 15. Blade positioned on wheel.

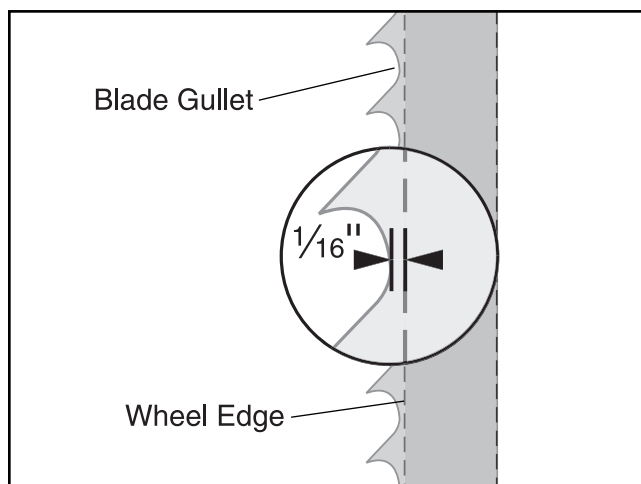


Figure 16. Illustration of proper blade position.

6. Tighten the blade with the blade tensioner as shown in **Figure 17**. Use the colored area on the tension gauge as a proper tension guide for your specific blade material.

Carbon Steel Yellow
 Bi-metal Orange

Note—Always adjust the pressure to the lowest rating of each colored area and then increase tension as needed (blades stretch as they warm up).



Figure 17. Tensioning blade with tensioner.

NOTICE

Always de-tension blade after use.



Adjusting Blade Guides

Each blade guide assembly consists of **Guide Blocks** and a **Support Bearing**.

The blade guides keep the blade stable during operation, so make sure they are properly adjusted before starting the bandsaw.

!WARNING

These instructions present a serious injury hazard if attempted while the machine is connected to power. **DO NOT** connect to power until instructed!

Guide Blocks

Each guide block consists of an upper and lower ceramic block that stabilizes the blade from up/down movement during operation.

The lower block is designed to remain in a fixed position, and the upper block is designed to be adjusted during each blade change. When the machine is new, the lower block is set at the factory and should not need to be adjusted (see *Section 8: Service Adjustments* for more information about the lower guide). The upper block, however, should be adjusted every time you install a new blade or re-install an old blade.

To adjust the upper guide block:

1. Loosen the guide block adjustment bolt shown in **Figure 18**.

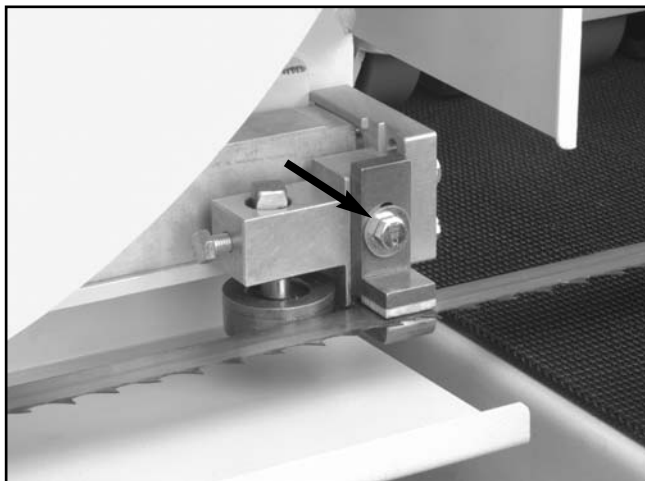


Figure 18. Guide block adjustment bolt.

2. Slide the upper guide block up, place a dollar bill (as a quick gauge for 0.004" clearance) underneath the upper guide block, then let the upper guide block slide down to sandwich the dollar between the blade and the upper guide block as shown in **Figure 19**.



Figure 19. Dollar bill between upper guide block and blade.

3. Keep the dollar bill in place and tighten the upper guide block.
4. Remove the dollar bill.
5. Repeat **steps 1-4** with the blade guide on the other side of the conveyor.

Support Bearing

The support bearing is positioned behind the blade to brace it from pushing backwards during a cut. **Figure 20** shows the support bearing components to clarify the adjustment instructions.

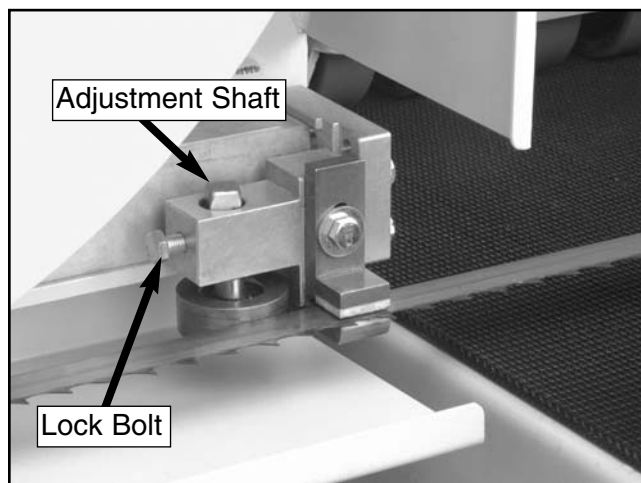


Figure 20. Support bearing components.

To adjust the support bearings:

1. Loosen the lock bolt approximately $\frac{1}{4}$ turn. Note—If you loosen the lock bolt too much, the support bearing will fall out of place.
2. Turn the adjustment shaft until the support bearing is positioned approximately 0.016" behind the back of the blade. Use a feeler gauge or four thicknesses of a dollar bill to check this.
3. Tighten the lock bolt, and repeat with the other support bearing.
4. Test the adjustment of the support bearings by spinning the wheels by hand, at full blade tension, in the same direction of operation. While you are spinning the wheels, the support bearings should not turn. (The support bearings should only turn during cutting operations.)



Connecting to Dust Collector

To be effective, the dust collection system that you connect to the resaw must be able draw at least 1000 CFM at the point where you connect the hose to the resaw. Note—*This number is an approximation and has been provided for estimation purposes only.*

To connect the resaw to a dust collector:

1. Attach a 4" dust hose to the dust port as shown in **Figure 21**, and be sure to tighten the hose clamp to ensure a snug fit.



Figure 21. Dust hose connected to dust port.



Connecting to Power Source

If you have performed all of the previous set up instructions, you are ready to connect the resaw to the power source. **DO NOT** connect the cord to the power source until instructed.

To connect the resaw to the power source:

1. Read through *Section 3: Circuit Requirements* to double-check that your setup follows the safety and circuit requirements, and that the power cord you have chosen meets the minimum requirements for this machine.
2. Open the electrical panel on the machine.
3. Connect the cord to the machine circuit breaker terminals shown in **Figure 22**.

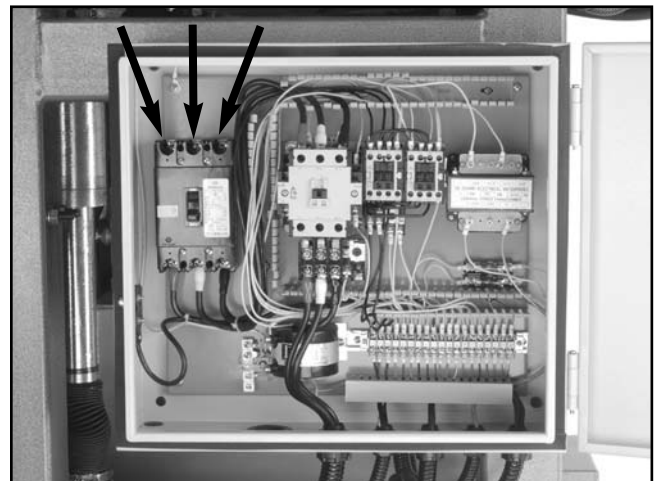


Figure 22. Circuit breaker terminal.

4. Close and latch the electrical panel on the machine.
5. **Shut off the main power at the power source circuit breaker** and install the cord to the disconnect switch.



Test Run

WARNING

Before starting the resaw, make sure you have performed the preceding assembly and adjustment instructions, and you have read through the rest of the manual and are familiar with the various functions and safety issues associated with this machine. Failure to follow this warning could result in serious personal injury or even death!

To test run the resaw:

1. Make sure the wheel cover is closed and all tools or other objects are cleared away from the resaw.
2. Put on safety glasses and make sure any bystanders are out of the way and also wear safety glasses.
3. Tension the blade.
4. Turn the *POWER ON* switch (shown in **Figure 23**) clockwise.

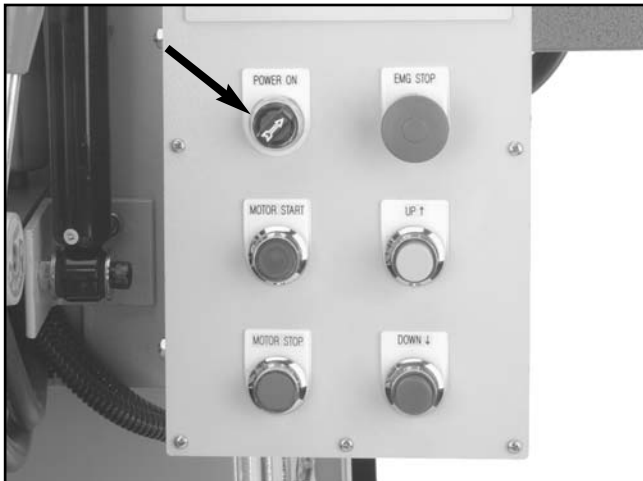


Figure 23. *POWER ON* switch.

5. Press the *UP* and *DOWN* buttons to make sure the resaw head moves in the proper direction.

— If the resaw head moves in the opposite direction as the buttons state, then the power needs to be disconnected and the power wires need to be switched at the circuit breaker in the electrical box.

6. Once you have performed **steps 1-4** and everything is okay with the machine and set up, press the *MOTOR START* button. As you are standing in front of the machine, make sure that the blade is moving from left to right.

7. Press the conveyor lever forward to test the conveyor belt. If the conveyor belt does not turn after pushing the conveyor lever forward, adjust the conveyor speed knob.

— If any problems occur, press the *EMG STOP* button. Investigate and correct the problem before operating the machine further. If you need help, refer to the troubleshooting section in the back of this manual.

— If you cannot easily locate the source of an unusual noise or vibration by yourself, please contact our service department at (570) 546-9663.



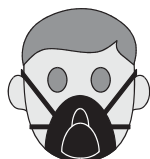
SECTION 6: OPERATIONS

Operation Safety

Your safety is important! Please follow the warnings below:

WARNING

Damage to your eyes, lungs, and ears could result from failure to wear safety glasses, a dust mask, and hearing protection while using this machine.



WARNING

Loose hair and clothing could get caught in machinery and cause serious personal injury. Keep loose clothing rolled up and long hair tied up and away from moving machinery.

NOTICE

The following section was designed to give instructions on the basic operations of this machine. However, it is in no way comprehensive of all of the machine's applications. **WE STRONGLY RECOMMEND** that you read books, trade magazines, or get formal training to maximize the potential of your machine.

Stock Preparation

The Model G0504 is capable of resawing rough cut lumber or slicing boards as thin as $\frac{1}{16}$ " with a high degree of precision.

Always make sure that any stock you plan on cutting is clean and free of nails, staples, or embedded stones.

Also, keep in mind that precision cuts require a much greater preparation process than do rough cuts.

To prepare the stock for a precision cut:

1. **Surface Plane on a Jointer**—The concave face of the workpiece should be planed flat on a jointer.
2. **Surface Plane on a Thickness Planer**—The opposite face of the workpiece should be planed flat with a thickness planer.
3. **Edge Joint on a Jointer**—The concave edge (viewed from end-to-end) of the workpiece should be edge jointed flat on a jointer. This flat edge will glide along the fence rollers during the resaw operation.



Conveyor Controls

The Model G0504 features an infeed conveyor and a return conveyor. The speed and engagement controls of each conveyor are independent of one another.

To operate the infeed conveyor:

1. Read the subsection titled “Control Panel” on **page 14** to become familiar with the control panel functions.
2. With the saw running, push the infeed conveyor engagement lever (**Figure 24**) forward (toward the blade) to start the infeed conveyor.
3. Turn the infeed conveyor speed dial (**Figure 24**) counter-clockwise to increase the speed and clockwise to decrease the speed.
4. Pull the engagement lever backward to stop conveyor.

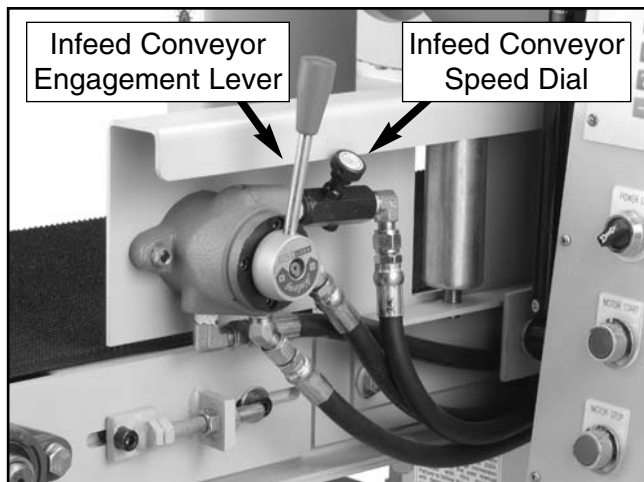


Figure 24. Infeed conveyor controls.

To operate the return conveyor:

1. Read the subsection titled “Control Panel” on **page 14** to become familiar with the control panel functions.
2. With the saw running, turn the return conveyor speed dial (**Figure 25**) counter-clockwise to start the return conveyor.
3. Continue to turn the dial counter-clockwise to increase the conveyor speed and turn the dial clockwise to decrease the conveyor speed.
4. Turn the dial clockwise as far as it will go to stop the conveyor.

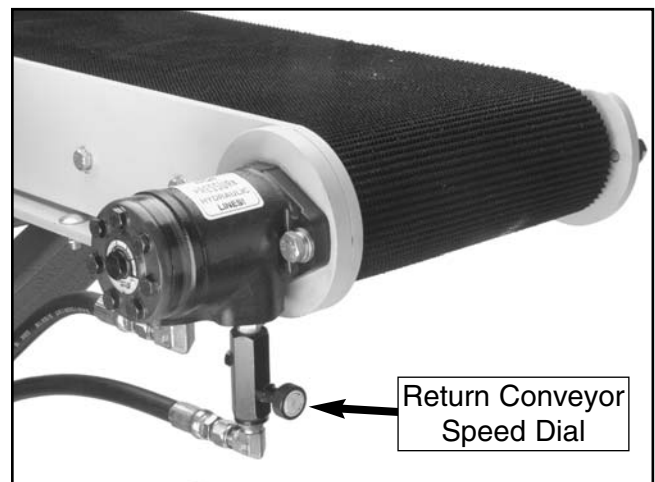


Figure 25. Return conveyor speed dial.



Setting Blade Height

The blade height is defined as the distance between the conveyor table and the bottom face of the bandsaw blade. There is an internal limit switch that will not allow the blade to be adjusted closer than $\frac{1}{4}$ " to the conveyor table. Note—Use the “Blade Memory Function” described in the next subsection when you want to make resaw cuts thinner than $\frac{1}{4}$ ", and be sure to cut from the top of the workpiece.

The blade height can be adjusted by using the keypad, or by pressing the *UP* and *DOWN* control panel buttons. After using either method of adjustment, the digital display will indicate the current blade height.

To set the blade height with the *UP* and *DOWN* control panel buttons:

1. Turn the control panel *POWER ON* switch clockwise to supply power to the control panel.
2. Press the *UP* button to move the blade up and press the *DOWN* button to move the blade down. Watch the digital display to gauge the blade height.

To set the blade height with the keypad:

1. Turn the control panel *POWER ON* switch clockwise to supply power to the control panel.
2. Press the *FUNC* key.
3. Enter the desired blade height to the nearest hundredth's place. For example, if you want the blade height to be 2", press 2, 0, 0 on the keypad. If you want the blade height to be $\frac{3}{4}$ ", press 7, 5.
4. After the blade height has been entered, press the *START* key.



Calibrating Digital Display

The digital display indicates the distance between the conveyor table and the bottom face of the bandsaw blade. The digital display needs to be calibrated to ensure that the displayed blade height and the actual blade height are the same.

To calibrate the digital display:

1. Resaw a piece of scrap wood. See “Resawing” on **page 28** for more information.
2. Measure the thickness of the workpiece that was cut off between the conveyor table and the blade. Note—Use a precise measuring tool such as calipers or a micrometer.
3. Press the *SET* key.
4. Enter the thickness value of the cut-off piece measured in **step 2**. For example, if the thickness is 1", press 1, 0, 0 on the key pad.
5. Press and hold the *SET* key for approximately 5 seconds or until the display stops flashing.

The digital display is now calibrated and all blade height values displayed will be the same as the actual distance between the conveyor table and the bottom face of the bandsaw blade.



Setting Blade Memory Function

The blade memory function is used when you want to make resaw cuts thinner than $\frac{1}{4}$ ". Because the blade cannot be adjusted closer than $\frac{1}{4}$ " to the table, resaw cuts thinner than $\frac{1}{4}$ " need to be cut from the top side of the workpiece.

The blade memory function allows the blade to be lowered a pre-determined distance each time you press the *MEMORY* button; therefore, you can make a series of cuts from the top side of the workpiece, all of the same thickness. *Note—Be sure to add the thickness of the blade, otherwise known as kerf, to the desired thickness of the cut-off pieces when setting the memory function. For example, if you want your cut-off pieces to be 1" thick and the kerf of the blade is 0.06", the memory function needs to be set to 1.06".*

To set the memory function:

1. Turn the control panel *POWER ON* switch clockwise to supply power to the control panel.
2. Press the *FUNC* key.
3. Enter the distance, to the nearest hundredth's place, that you want the blade to lower each time you press the *MEMORY* button. For example, if you want the blade to lower 2.06", press 2, 0, 6 on the key pad. If you want the blade to lower 0.56", press 5, 6.
4. Press and hold the *SET* key for approximately 5 seconds or until the display stops flashing.
5. Press the *MEMORY* button and the blade will automatically lower the distance set into the memory function.

Note—For best results, make a few cuts while using the MEMORY button, measure the workpiece, and adjust the memory setting according to the measurements of the cut-off workpiece.



Resawing

To perform a resawing operation:

1. Make sure the blade is installed and tensioned correctly. See "Installing Blade" on **pages 19-21** for more information.
2. Make sure the blade is tracking correctly. See "Adjusting Blade Guides" on **pages 21-22** for more information.
3. Turn the control panel *POWER ON* switch clockwise to supply power to the machine.
4. Set the blade height at the control panel. See "Setting Blade Height" on **page 27**. *Note—The accuracy of the blade height shown on the digital display can only be assured if the calibration process has been performed. See **page 29** for more information on calibrating the digital display.*
5. Press the *MOTOR START* button to start the bandsaw blade.
6. Push the infeed conveyor engagement lever forward to start the infeed conveyor. Turn the infeed conveyor speed dial counter-clockwise to increase the speed and clockwise to decrease the speed. See "Conveyor Controls" on **page 26** for more information.
7. Recheck the blade tension.
8. Make sure the workpiece has two sides that are relatively flat and parallel with each other.
9. Begin feeding the workpiece under the front pressure rollers with the jointed edge against the guide rollers, as shown in **Figure 26**.

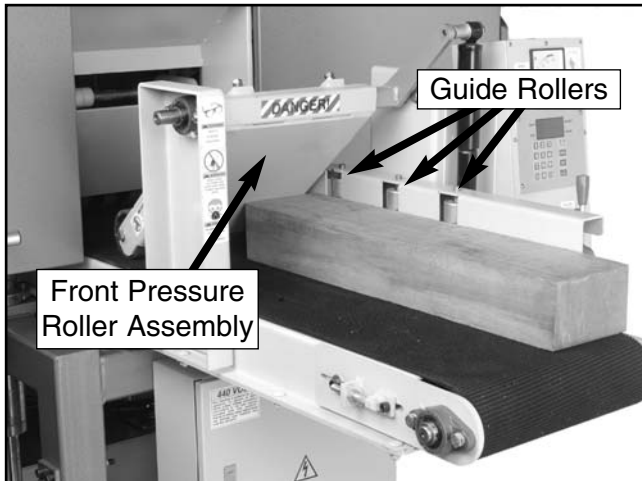


Figure 26. Feeding the workpiece through the bandsaw.

10. Watch the load meter (**Figure 27**) at the top of the control panel. The meter displays the amperage load that is being placed on the machine. Adjust the infeed conveyor feed rate until the meter reads between 25-30 Amps during the cutting operation.

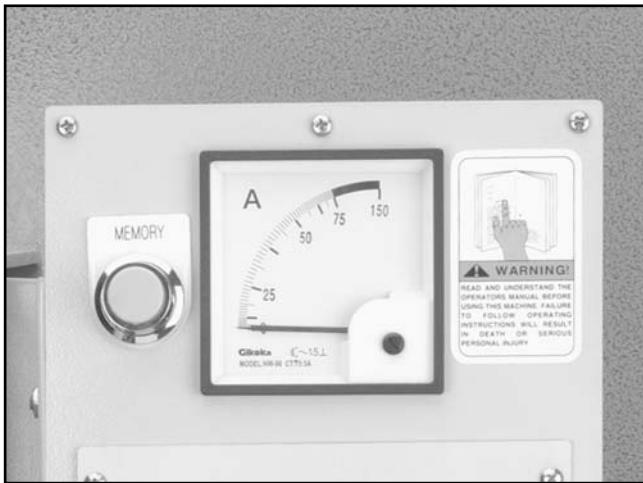


Figure 27. Load meter.

11. Receive the workpiece on the outfeed side of the machine. Note—*If a second person is receiving the workpieces, use the return conveyor to send them back to the person on the infeed side.*

NOTICE

Always de-tension blade after use.



Blade Information

Blade choices are limited due to the specialized nature of the Model G0504. The only variables when selecting a blade are the type of cutting tooth and the number of teeth-per-inch (Tooth Pitch).

Blade Tooth Type

Carbon Steel—The least expensive type, carbon steel blades are adequate for most cutting applications; however, they dull quickly and for economical reasons they are usually replaced rather than resharpened.

Carbide-Tipped—The most expensive type, carbide-tipped blades are designed for continuous use in production shop situations. They hold a sharp edge longer than carbon steel and they can be resharpened many times before needing to be replaced.

Tooth Pitch

Tooth pitch refers to the number of teeth-per-inch. The more teeth-per-inch, the smoother the resulting cut, but the feed rate must be relatively slow. The less teeth-per-inch, the rougher the resulting cut, but the feed rate can be set faster. Some trial and error may be necessary to find the right combination of cut quality, tooth pitch and feed rate.

Blade Length

The required blade length for the Model G0504 is 180".

Blade Width

The required blade width for the Model G0504 is 1".

Blade Care

The resaw blade is a delicate piece of steel that is subjected to tremendous strain. You can obtain longer use from the blade if you give it fair treatment and always use the appropriate feed rate for your operation.

A clean blade will perform much better than a dirty blade. A dirty blade passes through the cutting material with much more resistance than a clean blade. This extra resistance will also cause unnecessary heat. Maintain your blades with a cutting blade lubricant like SLIPIT® (Model G5562/3 in the Grizzly Catalog).

Blade Breakage

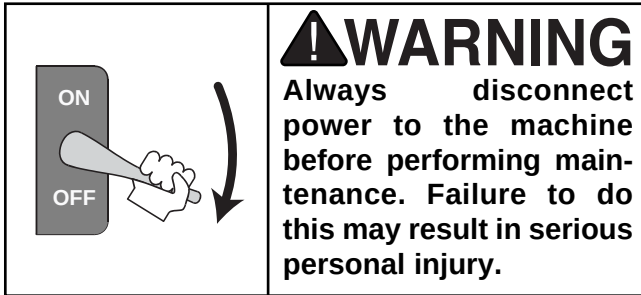
Blade breakage is unavoidable, in some cases, since it is the natural result of the peculiar stresses placed on the blade. Blade breakage is also due to avoidable circumstances, which is most often the result of poor care or judgement on the part of the operator when mounting or adjusting the blade or support guides.

The most common causes of blade breakage are:

- Not releasing blade tension after use.
- Faulty alignment or adjustment of the guides.
- Using a blade with a lumpy or improperly finished braze or weld.
- Feeding the workpiece too fast.
- Tooth dullness or absence of sufficient set.
- Excessive or too little blade tension.
- Running the bandsaw excessively when not resawing.



SECTION 7: MAINTENANCE



Cleaning

Inside Wheel Cover

To keep the bandsaw working properly, regularly open the wheel cover and vacuum any sawdust from the machine that did not make it into the dust collector.

Conveyor Belts

Use compressed air to clean the built-up sawdust from the conveyor belts. *Eye injuries frequently occur when cleaning with compressed air—wear safety glasses to protect yourself! Also wear a dust mask or respirator to protect your lungs from airborne dust particles.*

Elevation Columns

Use a dry rag to remove sawdust from the elevation columns and wipe them down with a light coat of oil.

Painted Surfaces

These areas may be cleaned with a dry or damp rag; however, make sure you DO NOT clean bare metal surfaces with a damp rag or they may rust.



Miscellaneous

Always be aware of the condition of your machine. Routinely check the condition of the following items and repair or replace as necessary:

- Loose mounting bolts
- Worn switch
- Worn or damaged blade
- Worn or damaged support bearings or guide bearings



V-Belts

To ensure optimum power transmission from the motor to the blade and to the hydraulic pump, the V-belts must be in good condition (free from cracks, fraying and wear) and operate under proper tension. Check the V-belts at least every 3 months; more often if the bandsaw is used daily.

See *Section 8: Service Adjustments* for instructions on properly tensioning the belts or for replacing the belts, if needed.



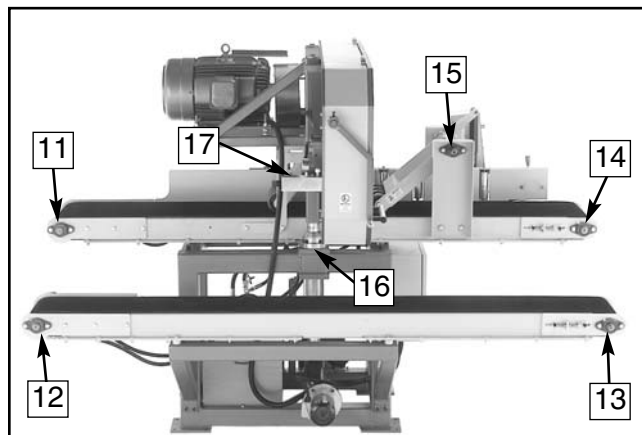
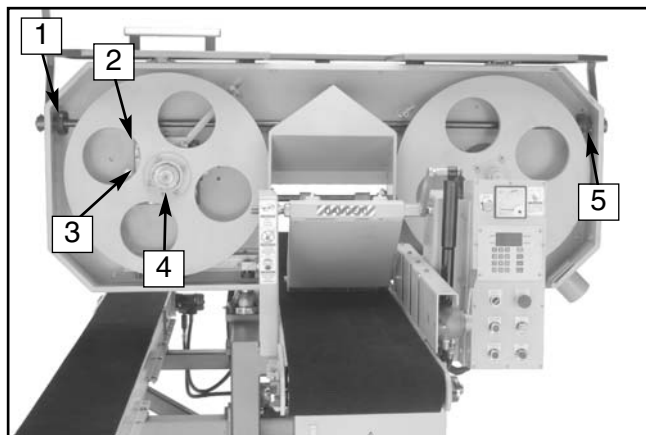
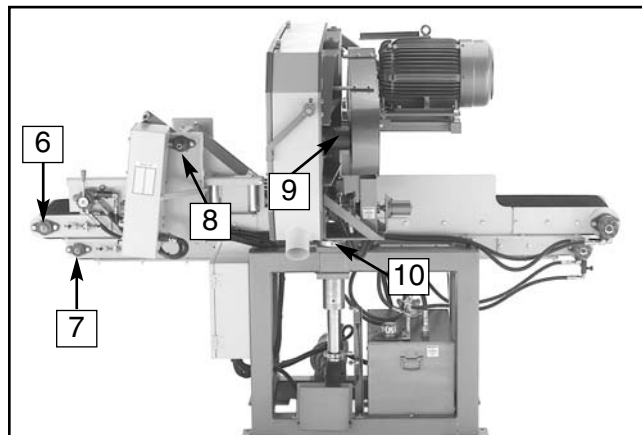
Bearings

Except for the bearings that are fitted with grease fittings, the other bearings are sealed and pre-lubricated and require no lubrication during their usable life. All bearings are standard sizes, and replacements can be purchased from our parts department or a bearing supply store.



Greasing

The photos on this page label the grease fittings by number for easy identification. Wipe clean and lubricate the grease fittings with two pumps of high-temp bearing grease. The proper greasing intervals are indicated by the boxes on the chart below. Note—*This page was designed to be copied and used as a check-off chart to help maintain a regular lubrication schedule.*



☒ Check white boxes after lubricating fittings. Date Started:

<i>G0504 GREASE SCHEDULE/CHECK-OFF CHART</i>							
MACHINE AREA	FITTINGS	HOURS OF USE					
		160	320	480	640	800	960
Main Wheels	4, 9						
Blade Tension Device	2, 3, 17						
Main Conveyor	6, 11, 14						
Return Conveyor	7, 12, 13						
Elevation Columns	10, 16						
Pressure Rollers	8, 15						
Wheel Cover Bearings	1, 5						

Note — 160 hours is the equivalent of 1 month of regular use.

Hydraulic Fluid Schedule

Check the hydraulic fluid level daily.

The hydraulic system controls the movement of the conveyor belts. In order for this system to function properly and operate at the correct temperature, the hydraulic fluid level in the tank should be $\frac{2}{3}$ full between the fill lines on the fluid sight window, which is located on the front of the tank (see **Figure 28**). Note—*As long as the fluid level is between the hi and low marks, it is okay.*

To add hydraulic fluid, remove the breather cap shown in **Figure 28**. Use an ISO VG 10—Antiwear 10 Hydraulic Fluid or equivalent.

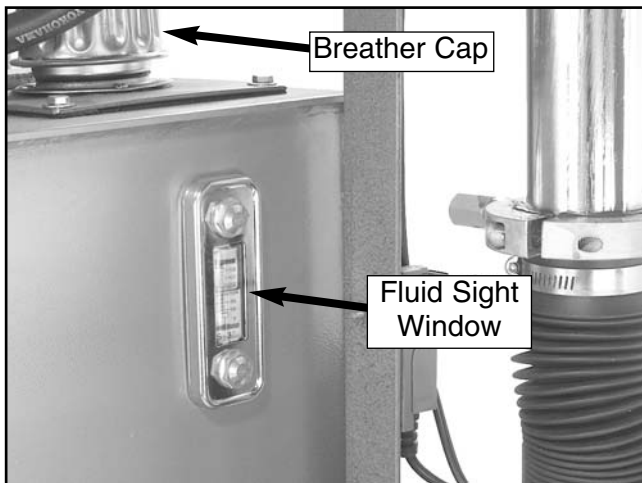


Figure 28. Hydraulic reservoir components.

Inspect and clean the breather cap and filler screen every 40 hours of regular use.

The breather cap is vented to allow the hydraulic system to breathe during operation. Below the breather cap is a plastic filler screen.

Visually inspect both the breather cap and the plastic filler screen. If there is visual contamination, clean both items with solvent and compressed air. Allow them to completely dry before installing back in the tank.



Hydraulic System Minor Service

The hydraulic system minor service consists of changing the fluid filter, cleaning the breather cap and filler screen, and inspecting the hydraulic fluid for signs of thermal breakdown, dust contamination, and water contamination.

Perform a “Minor Service” every 960 hours or every 6 months of regular use.

WARNING

The hydraulic system on this machine creates very high pressure and the hydraulic fluid gets hot. Always stop the resaw, open the conveyor speed valves, make sure the pressure gauge reads 0 PSI, and make sure the fluid cools down before removing any lines or servicing the hydraulic system.

To change the filter:

1. Read and understand the hydraulic safety instructions on page 6 before continuing!
2. Disconnect the two hydraulic lines that are over the filter cap and remove the pipe fitting so there is clear access directly over the filter cap, as shown in **Figure 29**.

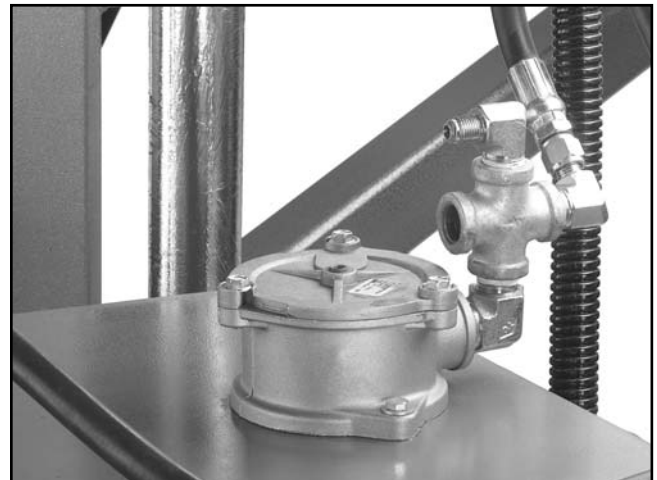


Figure 29. Hydraulic lines and fitting removed from above the filter cap.

3. Remove the filter cap by **COMPLETELY** removing the three bolts that secure it in place.
4. Set aside the filter cap spring and O-ring, so that they do not fall into the tank when you remove the filter.
5. Lift the filter assembly out of the tank as shown in **Figure 30**.

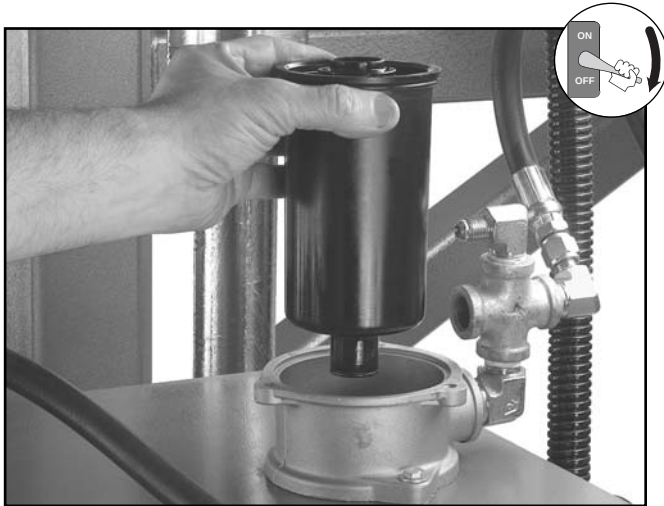


Figure 30. Removing filter assembly from tank.

6. Separate the filter from the filter housing by pulling them apart as shown in **Figure 31**. *Note—If you only removed a bare filter, then the housing is still mounted in the tank. Remove it for cleaning.*



Figure 31. Separating filter from filter housing.

7. Remove the O-ring from the shoulder of the filter housing and clean the filter housing in a solvent tank. *Note—DO NOT get solvent on O-rings or they will be damaged.*

8. Dry the filter housing to remove any excess solvent and replace the O-ring.
9. Rub clean hydraulic fluid on the O-ring that is mounted on the bottom of the new filter and insert the new filter into the filter housing.
10. Install the O-ring on the filter housing shoulder, apply clean hydraulic fluid to it, then drop the entire filter housing in the tank in the same position as it was removed (shoulder side up).
11. Replace the filter cap spring and O-ring, and start the filter cap bolts by threading them into their holes two or three turns.
12. Place the filter cap on the spring so the prongs fit in the center of the spring, and push down and twist the cap into place.
13. Tighten the filter cap bolts in an even manner, replace the fitting, and reconnect the hydraulic lines.

To inspect the hydraulic fluid:

1. Look at the color of the hydraulic fluid in the sight window.
 - If the fluid is milky in appearance, then the hydraulic fluid is contaminated with water. Repair leaks or fix the source of the problem and perform a major service.
 - If the fluid is dark brown or opaque, then the hydraulic fluid is severely contaminated or thermal breakdown has occurred. Correct the source of the contamination or which component is causing thermal breakdown, and perform a major service.
2. Smell the hydraulic fluid (remove breather cap).
 - If the fluid smells rancid or burnt, then thermal breakdown has most likely occurred. Correct the component that is causing thermal breakdown and perform a major service.



Hydraulic System Major Service

The hydraulic system major service consists of performing a complete “Minor Service,” draining the old hydraulic fluid, cleaning the tank screen, cleaning the tank, and filling the tank with new fluid.

WARNING

The hydraulic system on this machine creates very high pressure and the hydraulic fluid gets hot. Always stop the resaw, open the conveyor speed valves, make sure the pressure gauge reads 0 PSI, and make sure the fluid cools down before removing any lines or servicing the hydraulic system.

The hydraulic tank, when filled correctly at the sight window, holds approximately 13.5 gallons of hydraulic fluid. Before draining the hydraulic fluid, make sure you have a drain pan that will hold that much fluid or make sure that you are prepared to drain the tank, plug the tank, empty your drain pan, drain the tank, and so forth.

To drain the hydraulic fluid:

1. Read and understand the hydraulic safety instructions on page 6 before continuing!
2. With your drain pan in place, remove the drain plug shown in **Figure 32**.

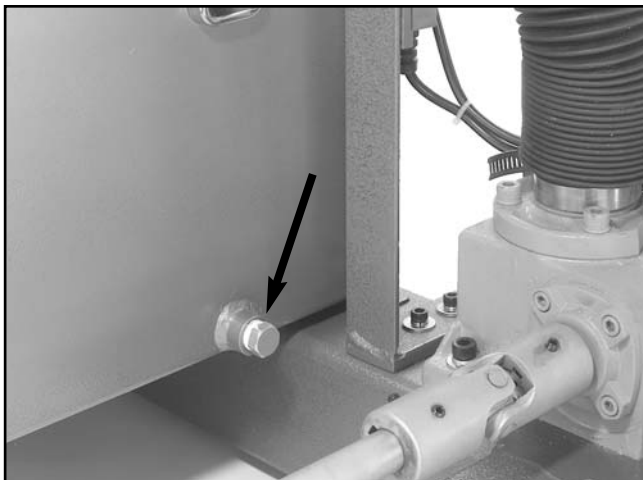


Figure 32. Drain plug for hydraulic tank.

G0504 16" Horizontal Resaw Bandsaw

3. Replace the drain plug after the hydraulic tank is completely drained.

To clean the tank screen:

1. Remove the access plate on top of the hydraulic tank as shown in **Figure 33**.

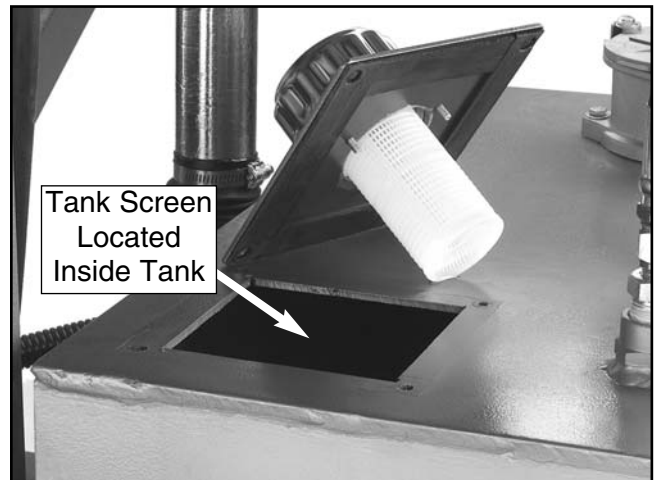


Figure 33. Access plate removed from tank.

2. Remove the tank screen, clean it with solvent and compressed air, and allow it to dry.
3. Re-install the tank screen AFTER you clean the bottom of the tank.

To clean the bottom of the tank:

1. Use a lint free rag to wipe up and remove any sludge from the bottom of the tank.
2. Use clean hydraulic fluid on a clean rag to wipe up additional contaminants from the bottom and sides of the tank.

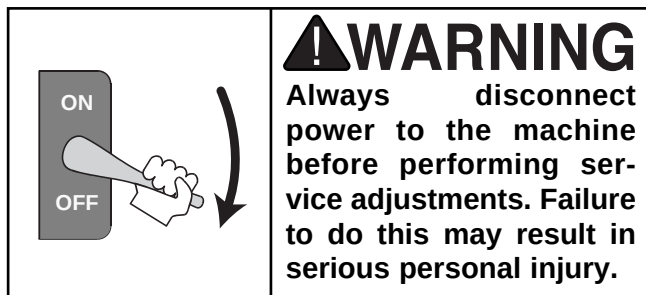
To fill the tank with new fluid:

1. Make sure that you have re-installed the tank screen, that the drain plug is tight, and that you have replaced the access plate on top of the tank.
2. Using an ISO VG 10—Antiwear 10 Hydraulic Fluid, fill the tank until the sight window is $\frac{2}{3}$ full between the hi and low marks on the sight window. Note—*This will take approximately 13.5 gallons.*





SECTION 8: SERVICE ADJUSTMENTS



About Service

This section is designed to help the operator with adjustments that were made at the factory and that might also need to be made during the life of the machine.

This section is provided for your convenience—it is not a substitute for the Grizzly Service Department. If any adjustments arise that are not described in this manual, then feel free to call the Grizzly Service Department at (570) 546-9663.

Similarly, if you are unsure of how to perform any procedure in this section, the Grizzly Service Department will be happy to guide you through the procedures or help in any other way.



Adjusting Lower Blade Guides

The instructions on adjusting the upper guide blocks and support bearing are given in *Section 5: Set Up*. This section focuses on adjusting the lower blade guides, which is a non-routine adjustment that would typically be done before the upper blade guide and support bearing would be adjusted.

To adjust the lower blade guides:

1. Disconnect the resaw from the power source!
2. Open the wheel cover for easy access to the blade guide assemblies.
3. Make sure the blade is tensioned in the same manner that will be used for operation.
4. Loosen the lateral adjustment bolts (shown in **Figure 34**).

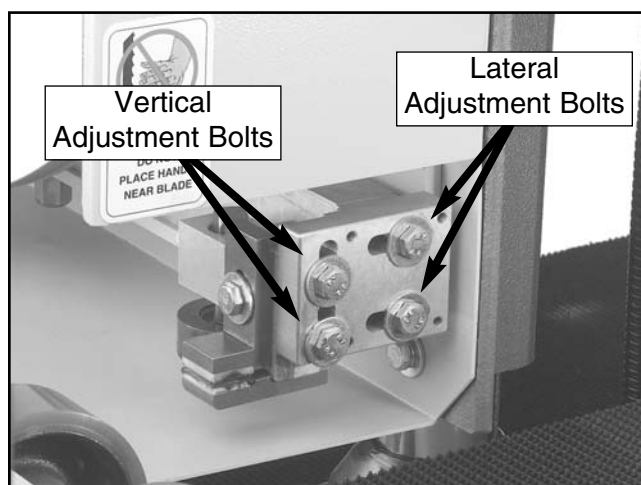


Figure 34. Lower guide block adjustment bolts.

5. Adjust the assembly so the blade guides are approximately $\frac{1}{16}$ " behind the gullets of the blade teeth, and tighten the lateral bolts.
6. Loosen the vertical adjustment bolts.
7. Adjust the lower blade guide so it barely touches the bottom of the blade, then tighten the vertical adjustment bolts.
8. Repeat **steps 4-5** on the other blade guide.
9. Adjust the upper guide blocks and the support bearings.
10. Close the wheel cover.



Adjusting V-Belt Tension

Properly tensioned V-belts help the Model G0504 operate at its best. However, adjusting the V-belts is not an exact science and does require personal judgement. Adjusting the belts too loose will decrease the performance of the machine and adjusting the belts too tight may cause premature wear of the bearings and other components attached to the belts.

On the Model G0504 there is a triple-drive V-belt system that connects the motor to the wheel pulley and a single-drive V-belt system that connects the wheel pulley to the hydraulic pump.

On both systems, the belts should deflect no more than $\frac{1}{2}$ " and not less than $\frac{1}{4}$ " when pressing the center of the pulleys with your index finger (see **Figure 35**).

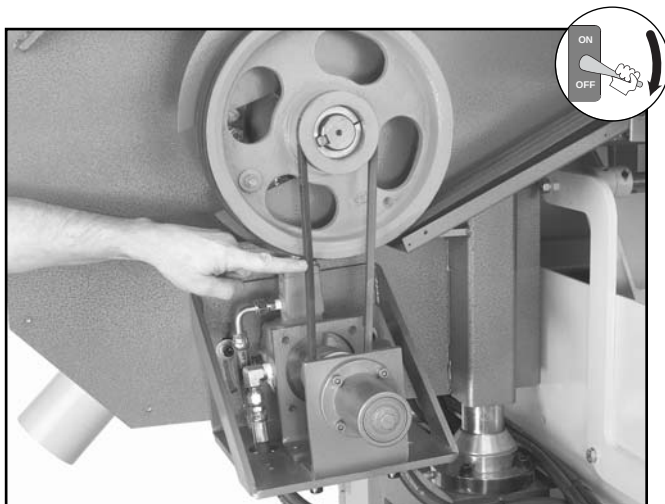


Figure 35. Checking V-belt tension.

To adjust the V-belt tension for the saw wheels:

1. **Disconnect the resaw from the power source!**
2. Remove the four attachment bolts shown in **Figure 36**, and remove the large pulley guard from the machine.

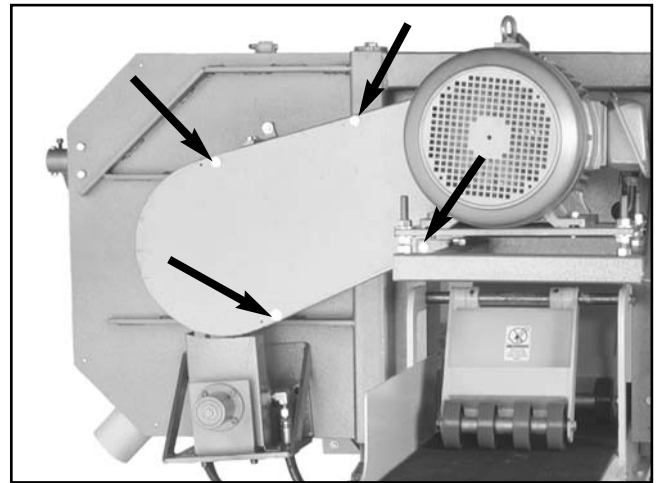


Figure 36. Large pulley cover attachment bolts.

3. To tension the three V-belts that connect the motor to the wheel pulley, adjust the tension by moving the motor mount nuts (see **Figure 37**) up or down until the belts are in the proper deflection range. Note—*The belts tighten when you move the motor mount up.*



Figure 37. Motor mount nuts (nuts on fourth corner not shown).

To adjust the tension for the hydraulic pump V-belt:

1. Remove the small pulley cover from the pump seat.

2. Adjust the belt tension by loosening the cap screws shown in **Figure 38**.

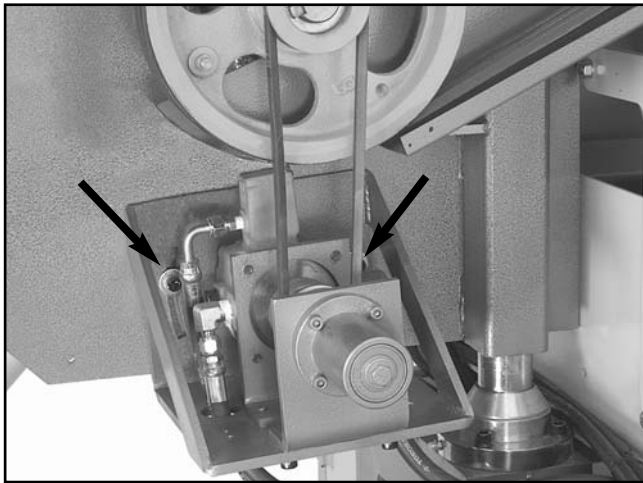


Figure 38. Pump seat cap screws.

3. Rotate the pump seat up or down until the belt has the proper deflection.
4. Tighten the cap screws to lock the pump seat in place.
5. Re-install the pulley covers.



Replacing V-Belts

If the belts deteriorate or break, they will need to be replaced. When replacing one of the belts that connect the motor to the wheel pulley, you should replace all three at the same time to ensure uniform belt tension.

To replace the belts that connect the motor to the wheel pulley:

1. **Disconnect the resaw from the power source!**
2. Read the previous subsection titled “Adjusting V-Belt Tension” to become familiar with the V-belt tension controls.
3. Remove the large pulley guard.
4. Adjust the motor mount nuts down as far as they will go.
5. Remove the hydraulic pump V-belt from the wheel pulley by loosening the oil seat cap screws and pivoting the pump seat up.
6. Remove and replace all three V-belts that connect the motor to the wheel pulley.
7. Re-install and tension the hydraulic pump belt on the wheel pulley.
8. Tension the newly installed V-belts and replace the belt cover.

To replace the V-belt that connects the hydraulic pump to the wheel pulley:

1. **Disconnect the resaw from the power source!**
2. Remove the large pulley guard that covers the wheel pulley.
3. Remove the small pulley guard that covers the hydraulic pump pulley.

4. Loosen the pump seat cap screws and pivot the pump seat up to release the belt tension.
5. Remove the two cap screws shown in **Figure 39** that secure the pulley bracket to the pump seat.

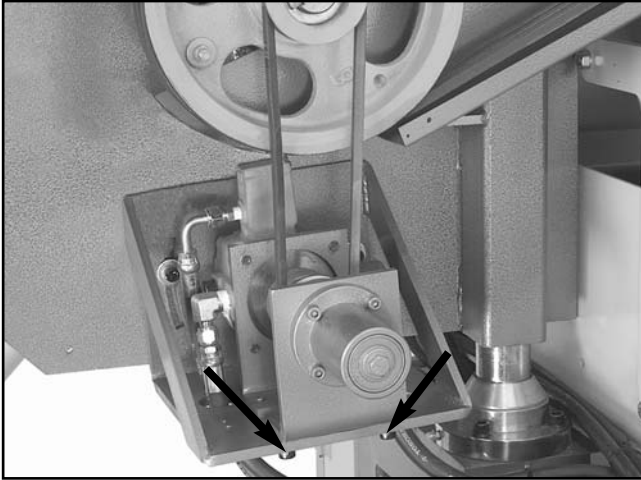


Figure 39. Cap screws securing pulley bracket.

6. Remove the pulley bracket w/assembly to split the connector and make it possible to remove the belt from the hydraulic pump pulley.
7. Remove the old V-belt and replace with a new V-belt.
8. Inspect the rubber seal that was between the connector pieces.
 - If the rubber seal is pliable and smooth, use it again.
 - If the rubber seal is dry and cracked, replace it.
9. Re-assemble the pulley bracket and tension the new V-belt.
10. Replace both pulley guards.



Adjusting Main Conveyor Table

The main conveyor table height can be adjusted left-to-right and front-to-back to make the table parallel to the blade in both directions. This is an involved procedure that requires you to cut up a piece of test stock and make many repeat adjustments. Because of the complexity of this procedure, we will first give instructions on checking the table, so that you can be sure you need to perform the adjustment.

Before attempting these procedures, you need to have a perfectly squared up piece of stock that is as wide as possible and is at least two feet long. The wider the stock, the more accurate your procedure will be (we recommend using the maximum width that the resaw will allow). Also, you need to make sure that your blade is in good condition, the blade is tracked/tensioned properly and the blade guides are properly adjusted.

To check the main conveyor table alignment:

1. Cut a $\frac{1}{4}$ " slice off of your squared-up test stock.
2. Using a dial caliper, measure the thickness of the cut piece at all four corners and in even locations along the edges of the stock. As you take these measurements, write them directly on the stock, near the location where you took the measurement (see **Figure 39**).

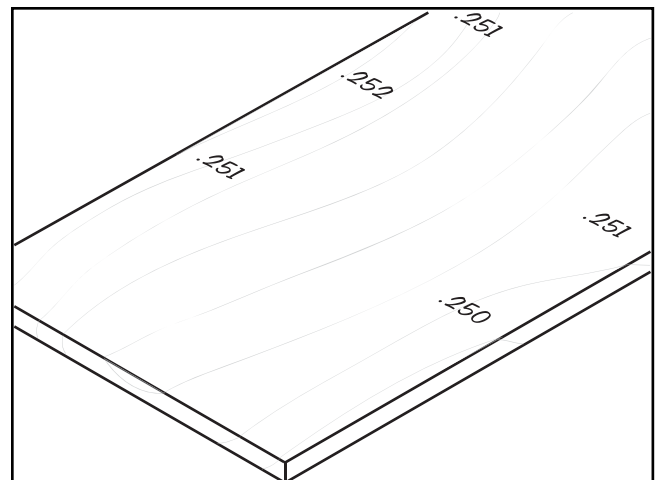


Figure 39. Test board with measurements.

3. Study the written measurements on your test piece. Note—*DO NOT place too much importance on the first and last six inches of the board, because the board will only have been under one pressure roller during that part of the cut.*

— If the measurements are more than 0.030" different from one side to the other, you should adjust the conveyor table.

To adjust the conveyor table:

1. **Disconnect the resaw from the power source!**
2. Use your test board to determine which direction the conveyor table needs to be moved. For example, if the right side of the board was thicker than the left side—you will need to move either the right side of the conveyor up or move the left side of the conveyor down.
3. Adjust the four adjustment bolts that control the conveyor table height as determined from **step 2**. Note—*For adjustment bolt locations see the adjustment bolt shown in Figure 40.*



Figure 40. Conveyor table adjustment bolts (1 of 4 shown).

4. Tighten the lock nuts on the adjustment bolts, connect the resaw to the power, and repeat the checking and adjusting steps until the measurements on your cut piece are within 0.030".



Tracking Conveyors

“Tracking” the conveyor belts means balancing the way they ride on the end rollers. The conveyors are tracking correctly when they are centered between the roller brackets on each side of the conveyor. If the conveyor belts start rubbing against the roller brackets, then you need to track them as described.

To set the conveyor tracking:

1. Loosen the two roller bracket cap screws (shown in **Figure 41**) about $\frac{3}{4}$ of a turn. Do this on the both sides of the conveyor.

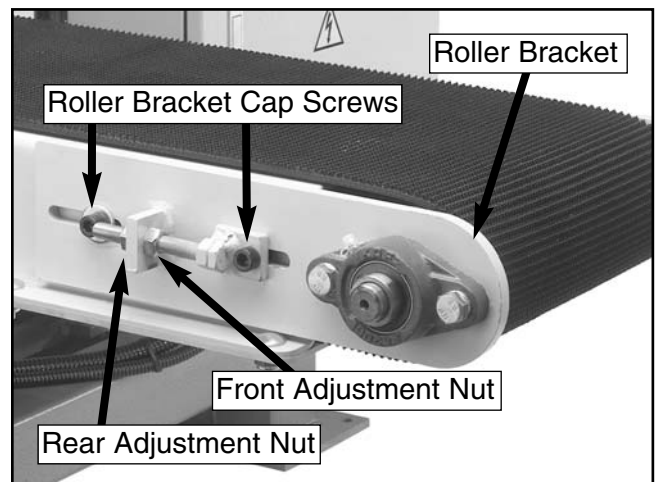


Figure 41. Roller bracket cap screws and adjustment nuts.

2. Loosen the rear adjustment nuts away from the bracket plates on both sides of the conveyor.
3. Start the conveyor belt.
4. On the side that the belt tracks toward, turn the front adjustment nut counter-clockwise half of a turn, and watch the belt tracking. Note—*The effect of the adjustment can sometimes take two minutes before the results are fully apparent.*

— If the tracking was not corrected by this adjustment, proceed to **step 5**. If the tracking was corrected, skip to **step 6**.

5. On the side that the belt tracks away from, turn the front adjustment nut clockwise half of a turn, and watch the belt tracking.

— If the tracking was not corrected by this adjustment, repeat **step 4**.

6. When the conveyor belt is tracking in the center of the roller brackets, run the conveyor for at least two minutes to ensure that it will remain tracking correctly.
7. Tighten the rear adjustment nuts against the bracket plates, then tighten the front adjustment nuts against the bracket plates to make sure that the tracking adjustment will not slowly change during normal operation.



Replacing Conveyors

Although the conveyor belts have slight differences in size and access, the replacement instructions are the same.

To replace the conveyor belts:

1. Start the conveyor belt that you want to replace.
2. Stop the conveyor belt when the conveyor belt seam (see **Figure 42**) is accessible.

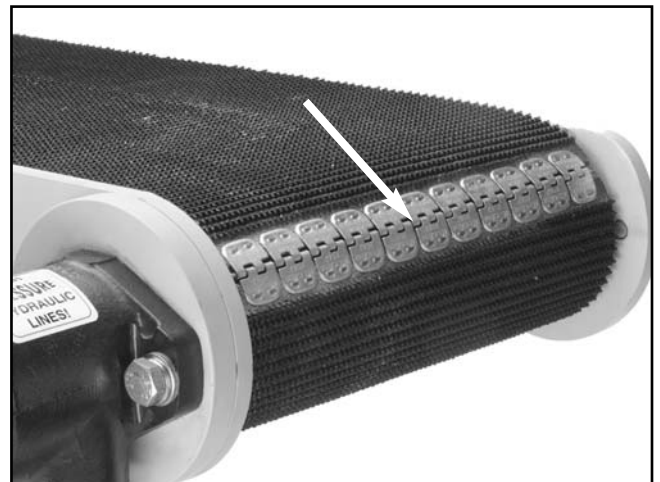


Figure 42. Conveyor belt seam.

3. **Disconnect the resaw from the power source!**
4. Loosen the roller bracket (see **Figure 43**) by turning the roller bracket cap screws $\frac{3}{4}$ of a turn.

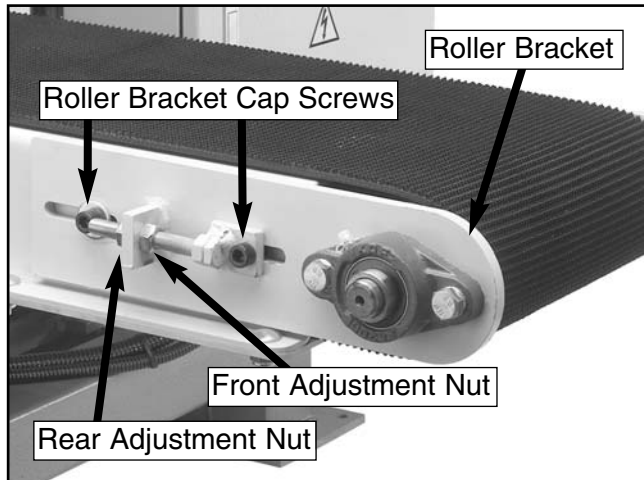


Figure 43. Roller bracket cap screws and adjustment nuts.

5. Loosen the rear adjustment nuts away from the bracket plate.
6. Mark the front adjustment nut with a felt-tipped pen or a piece of tape, and thread the front adjustment nut all the way up, while keeping track of the number of full turns that you moved the nut.

Note—Write the number of turns down, so you do not forget. Remembering this number is an important part of the re-assembly process.

7. Slide the roller brackets toward the body of the resaw to loosen the belt.
 8. Remove the stiff cable from the center of the seam to separate it.
 9. Remove the old conveyor belt from the conveyor table, and replace the new conveyor belt in its place.
 10. Mesh the seam “teeth” together on the new belt, and insert the stiff cable into the center of the seam to lock it together.
 11. Slide the roller brackets away from the body of the resaw to tighten the belt.
 12. Turn the front adjustment bolts the exact number of rotations that you turned them when you loosened them.
- Note—The new belt may be tighter than the old one because it has not been broken-in. If this is the case, deduct one or two turns from your original number of turns.*
13. Run the conveyor belt to check the tracking. If the belt starts tracking to one side, stop the resaw and perform the “Tracking Conveyors” instructions that are located on **pages 41-42**.



Blade Tracking and Wheel Alignment

Blade tracking on the Model G0504 consists of adjusting the wheels to be nearly coplanar (coplanar=both wheels even and parallel), but having the outside edge of the wheel approximately 0.020"-0.040" behind the inside edge of the wheel to compensate for wheel toe-in when the blade is fully tensioned.

Because of the large size of this machine and the wheel toe-in factor, this procedure is time consuming and requires a great deal of trial and error. Make sure you really need to perform this procedure before attempting it.

Also, to complete this procedure you will need to make four precision gauge blocks and have a 6' long straightedge.

To adjust the wheels to be coplanar:

1. **Disconnect the resaw from the power source!**
2. Open the wheel cover.
3. Remove the blade.
4. Using 2x4's, make four precision gauge blocks to the specifications shown in **Figure 44**.

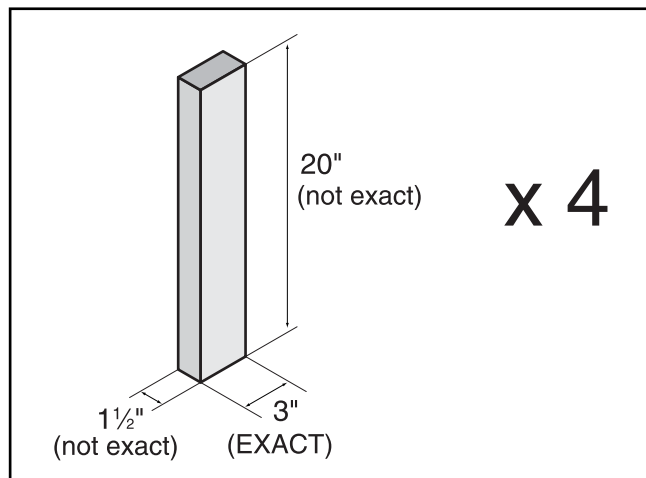


Figure 44. Precision gauge block dimensions.

5. Clamp the gauge blocks to the wheels as shown in **Figure 45**.

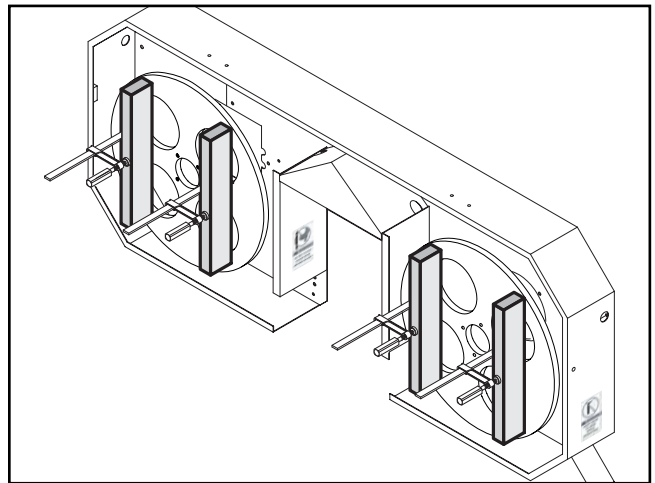


Figure 45. Precision gauge blocks clamped in position on wheels.

6. Place the straightedge across the top of the gauge blocks, as shown in **Figure 46**, and examine how the wheels line up with each other.

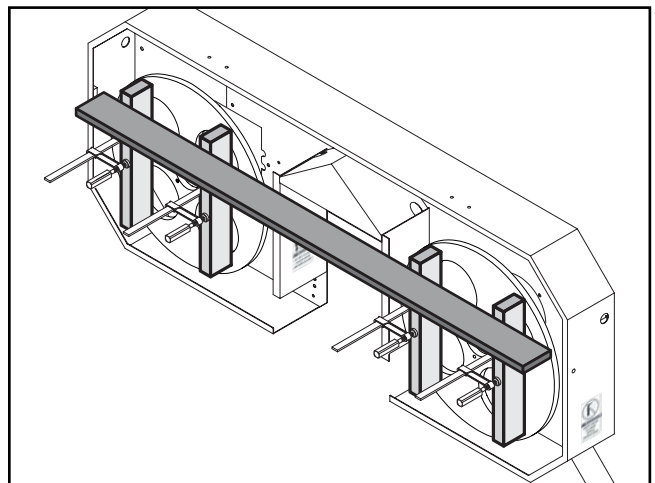


Figure 46. Straightedge placement when checking the upper portion of the wheels.

— If the wheels are properly aligned, the straightedge will touch both inside gauge blocks and there will be a 0.020"–0.040" gap between the straightedge and the outside gauge blocks, as shown in **Figure 47**. If this is the case, skip to **step 9**.

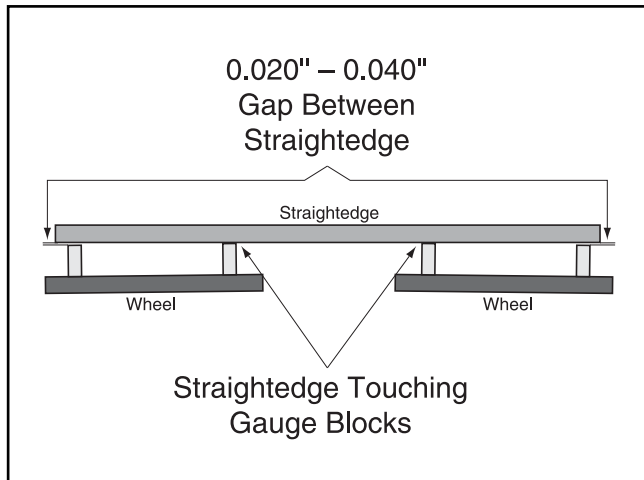


Figure 47. Overhead view of straightedge on blade wheel gauge blocks.

— If the wheels are not positioned as shown above, determine which direction they need to move in order to be correct, then proceed to **step 7** to begin the adjustment process.

7. Look at the backside of the wheel guard and learn the controls shown in **Figures 48 & 49** by reading the text that follows.

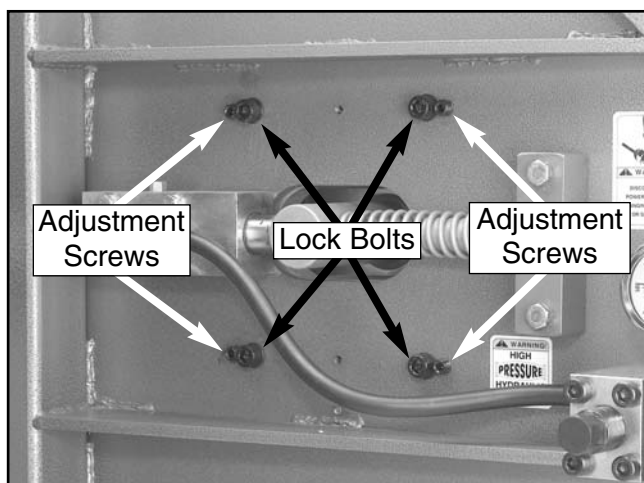


Figure 48. Tension wheel adjustment bolts.

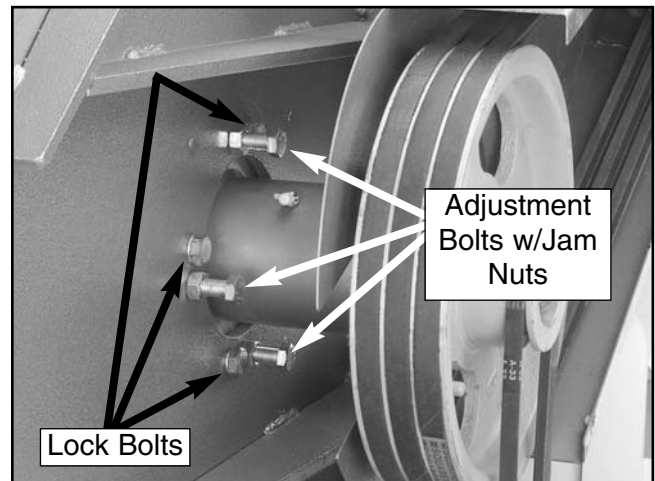


Figure 49. Drive wheel adjustment controls (fourth bolt hidden behind shaft in this picture).

Movement Direction—The bolt position around the wheel shaft determines the part of the wheel that will move when that bolt is turned.

Moving Forward—To move part of the wheel forward, loosen the appropriate lock bolts the same amount that you will tighten their neighboring adjustment bolts. (By “appropriate” we mean the bolts that control the direction that your wheel needs to be moved.) In the case of the main drive wheel adjustments, always loosen the jam nuts before moving the adjustment bolts, and always tighten the jam nuts after moving the adjustment bolts.

Moving Backward—To move part of the wheel backward, loosen the appropriate adjustment bolt, then tighten the neighboring lock bolt.

8. Adjust the wheels as necessary until the wheel position is correct when checked with the straightedge and continue to **step 9**.

9. Place the straightedge across the bottom of the gauge blocks, as shown in **Figure 50**. The wheels should line up in the same manner as described in **step 6**.

— If they do not, follow **steps 7–8** to correct them.

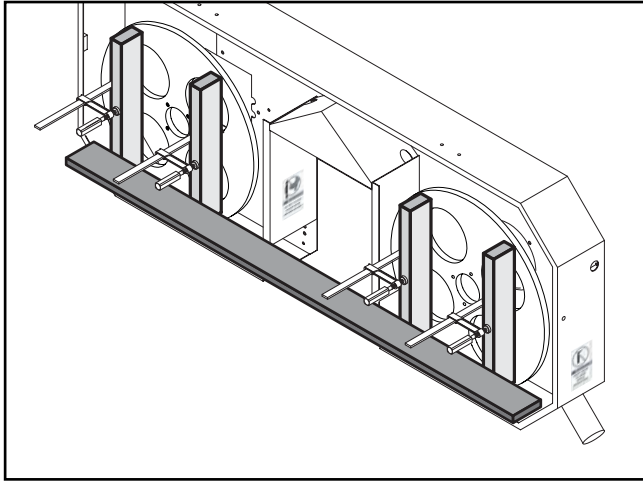


Figure 50. Straightedge placement when checking the lower portion of the wheels.

10. After the wheels are positioned correctly, install and tension the blade, and adjust the guide bearings out of the way of the blade.
11. Check the new position of the wheels. Ideally the gauge blocks will all be perfectly aligned with each other, as illustrated in **Figure 51**.

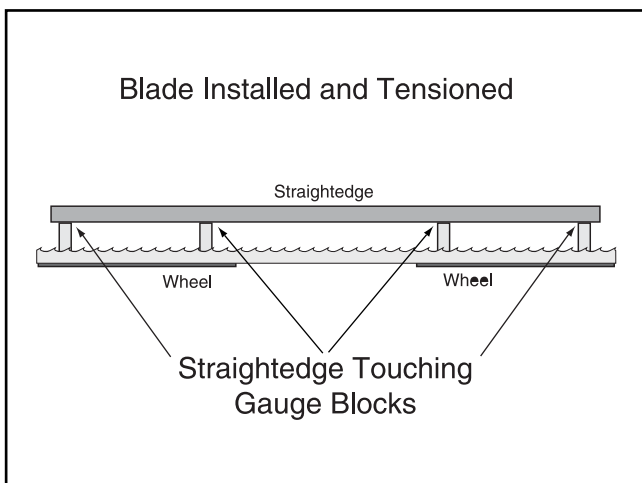


Figure 51. Overhead view of wheel position when checking with a straightedge and the blade is installed and tensioned.

— If the gauge blocks are aligned within 0.040" of each other, continue to **step 12**.

— If the gauge blocks are positioned more than 0.040" from each other, repeat steps 6 & 9, and make the new adjustments according to the change you noticed after tensioning the blade.

12. Remove the gauge blocks and clamps, and spin the wheels by hand in the direction of normal operation to check the blade tracking. You can fine tune the blade tracking by adjusting the blade tension up or down—just make sure to stay in the color range on the tension scale for your particular blade.
13. After the blade is tracking correctly, prepare the saw for a test run by adjusting the guide bearings, closing the wheel cover, and connecting the machine to the power source.
14. Test run the resaw and repeat this entire section if the blade does not track correctly.





SECTION 9: REFERENCE INFO

The following pages contain aftermarket accessories information, the machine data sheet, parts diagrams, parts lists, wiring diagrams, troubleshooting information and Warranty/Return information for your Model G0504.

If you need parts or help in assembling your machine, or if you need operational information, call the Grizzly Service Department. Trained service technicians will be glad to help you.

If you have any comments regarding this manual, please write to Grizzly at the address below:

Grizzly Industrial, Inc.
c/o Technical Documentation
P.O. Box 2069
Bellingham, WA 98227-2069

We recommend you keep a copy of our current catalog for complete information regarding Grizzly's warranty and return policy. If you need additional technical information relating to this machine, or if you need general assistance or replacement parts, please contact the Service Department at the location listed below.

Grizzly Industrial, Inc.
1203 Lycoming Circle
Muncy, PA 17756
Phone: (570) 546-9663
Fax: (800) 438-5901
E-Mail: techsupport@grizzly.com
Web Site: <http://www.grizzly.com>



Aftermarket Accessories

Lenox® Blades

<u>MODEL</u>	<u>TYPE</u>	<u>WIDTH</u>	<u>GAUGE</u>	<u>TPI</u>
H4874	Carbon	1"	0.035"	1.3
H4875	Carbide Tip	1"	0.035"	2-3
H4876	Carbide Tip	1"	0.035"	3-4

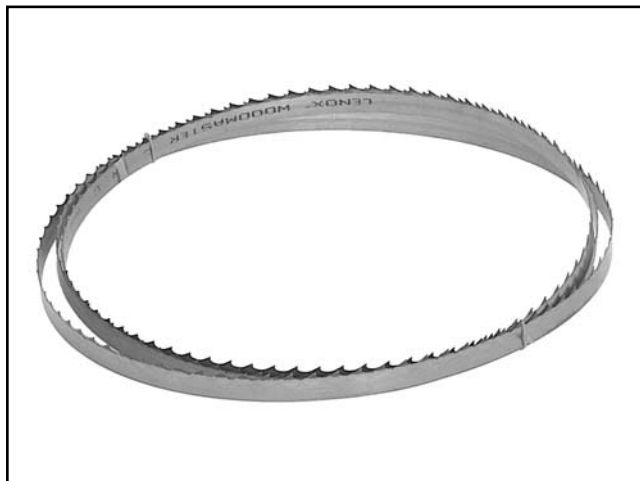


Figure 52. Lenox® bandsaw blade.





MACHINE DATA SHEET

Customer Service #: (570) 546-9663 • To Order Call: (800) 523-4777 • Fax #: (800) 438-5901

MODEL G0504 16" HORIZONTAL RESAW BANDSAW

Design Type Horizontal Floor Model

Overall Dimensions:

Conveyor Table 16" W x 102" D
Height From Floor To Table 40"
Height From Floor To Return Table 30"
Overall Height (With Door Open) 83½"
Overall Width 85"
Overall Depth 108"
Shipping Weight 4080 lbs.
Net Machine Weight 3300 lbs.
Crate Size 73" x 48" x 61"
Footprint 32¼" W x 45¼" L

Capacities:

Maximum Workpiece Width and Height 16" W x 10" H
Minimum Workpiece Length 16" L
Distance From Blade to Conveyor Table ¼"-10"
Saw Wheel Diameter Ø28" x 15/16"W
Saw Blade Size 180" L x 1" W x .035" T (.063 kerf)
Saw Blade Speed 7300 FPM
Feed Conveyor Belt Size 15¼" x 215¾" x 1pc
Return Conveyor Belt Size 11¼" x 215¾" x 1pc
Feed Speed 0-82 FPM

Construction:

Frame Steel
Conveyor Table Steel
Conveyor Belt Rubber
Wheels Steel
Wheel Cover Pre-Formed Steel
Blade Guides Ceramic
Pressure Roller 4" Cast Iron w/Polyurethane Tire

Main Motor:

Type TEFC Induction
Horsepower 25 HP
Phase / Voltage 3-Phase / 220V/440V
Amps 60/30A
Cycle / RPM 60 Hertz / 1725 RPM
Switch 220V Magnetic w/Thermal Overload Protector
Bearings Shielded & Lubricated Ball Bearings
Hydraulic Pressure 775 PSI (55KG/CM²)

Elevation Motor:

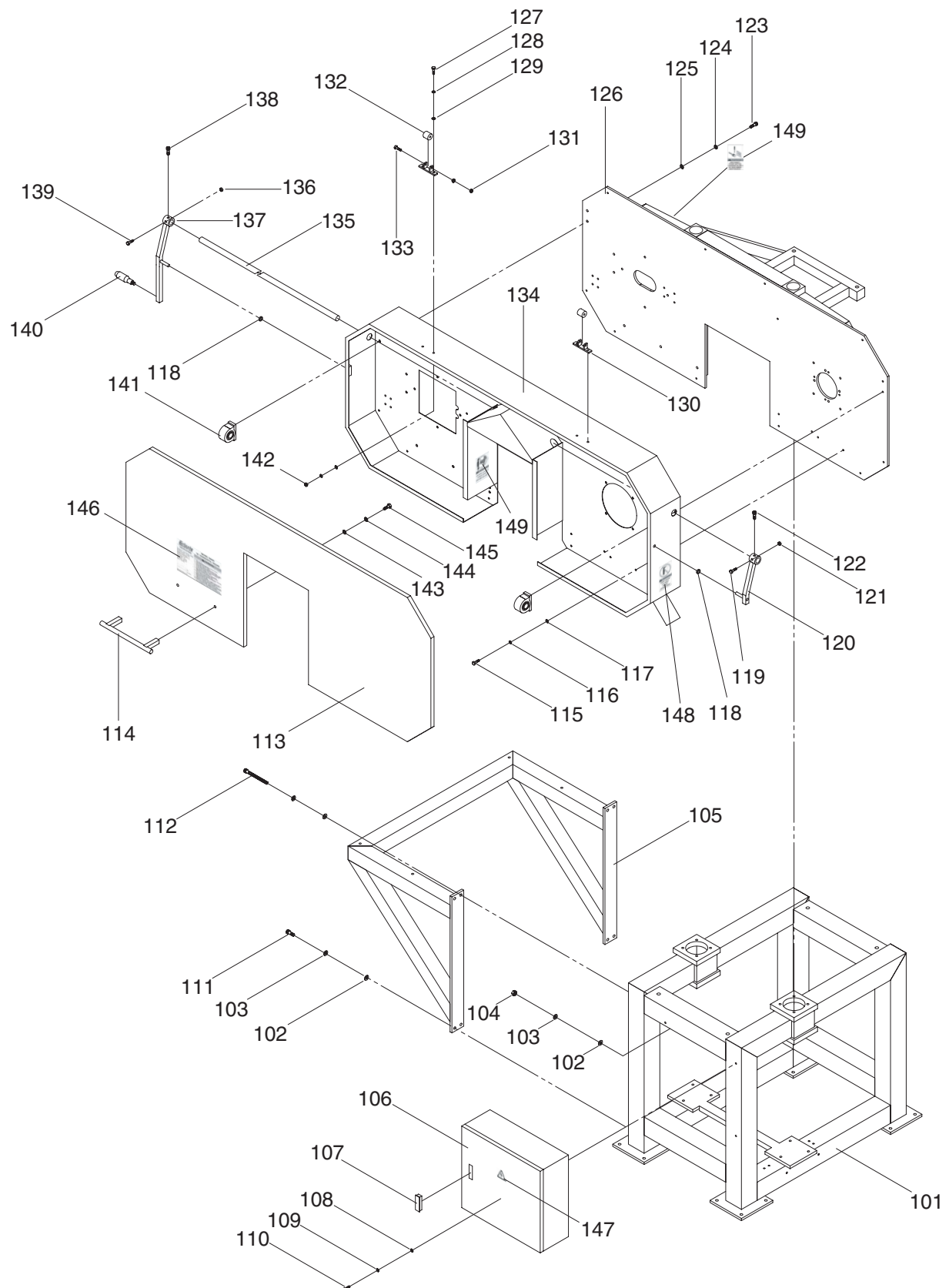
Type TEFC Induction
Horsepower ¼ HP
Phase / Voltage 3-Phase / 220V/440V
Amps 1.5/0.75A
Cycle / RPM 60 Hertz / 1725 RPM

Features:

..... 4" Dust Port
..... Return Conveyor
..... Hydraulic Blade Tension Control & Indicator
..... Powered Saw Wheel Elevation
..... Digital Position Controller for Accurate Saw Wheel Positioning

Specifications, while deemed accurate, are not guaranteed.

G0504 Wheel Guard and Frame Assembly

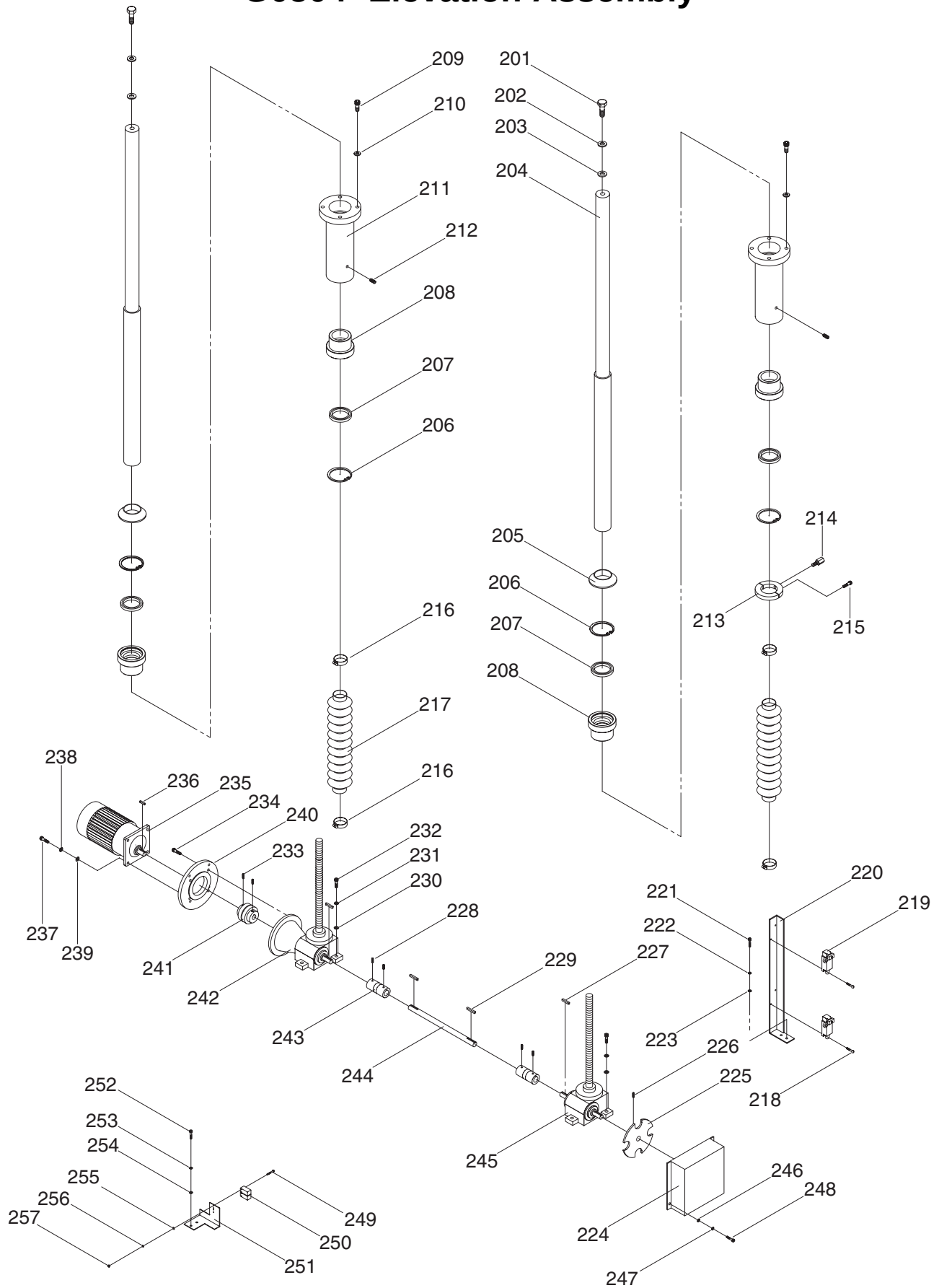


G0504 Wheel Guard and Frame Assembly

REF	PART #	DESCRIPTION
101	P0504101	FRAME
102	PW06M	FLAT WASHER 12MM
103	PLW05M	LOCK WASHER 12MM
104	PN09M	HEX NUT M12-1.75
105	P0504105	CONVEYOR SUPPORT
106	P0504106	ELECTRIC BOX
107	P0504107	DOOR HINGE
108	PW01M	FLAT WASHER 8MM
109	PLW04M	LOCK WASHER 8MM
110	PB09M	HEX BOLT M8-1.25 X 20
111	PSB77M	CAP SCREW M12-1.75 X 30
112	PSB77M	CAP SCREW M12-1.75 X 30
113	P0504113	SAW WHEEL COVER
114	P0504114	HANDLE
115	PB87M	HEX BOLT M8-1.25 X 15
116	PLW04M	LOCK WASHER 8MM
117	PW01M	FLAT WASHER 8MM
118	P0504118	PLASTIC SPACER
119	PB28M	HEX BOLT M8-1.25 X 60
120	P0504120	OPEN ARM-RIGHT
121	PN03M	HEX NUT M8-1.25
122	PSB61M	CAP SCREW M10-1.5 X 20
123	PSB72M	CAP SCREW M10-1.5 X 30
124	PLW06M	LOCK WASHER 10MM
125	PW04M	FLAT WASHER 10MM

REF	PART #	DESCRIPTION
126	P0504126	SAW WHEEL FRAME
127	PB09M	HEX BOLT M8-1.25 X 20
128	PLW04M	LOCK WASHER 8MM
129	PW01M	FLAT WASHER 8MM
130	P0504130	ROLLER BRACKET
131	PN03M	HEX NUT M8-1.25
132	P0504132	COVER ROLLER
133	PB28M	HEX BOLT M8-1.25 X 60
134	P0504134	SAW WHEEL GUARD
135	P0504135	CONNECT ROD
136	PN03M	HEX NUT M8-1.25
137	P0504137	OPEN ARM-LEFT
138	PSB61M	CAP SCREW M10-1.5 X 20
139	PB28M	HEX BOLT M8-1.25 X 60
140	P0504140	HANDLE
141	P0504141	CASING BEARING UCPA 205
142	PN03M	HEX NUT M8-1.25
143	PW01M	FLAT WASHER 8MM
144	PLW04M	LOCK WASHER 8MM
145	PB26M	HEX BOLT M8-1.25 X 30
146	P0504146	G0504 WARNING/ID LABEL
147	PLABEL-14	ELECTRICITY LABEL
148	PLABEL-20	DON'T OPEN LABEL
149	PLABEL-18	UNPLUG BANDSAW LABEL

G0504 Elevation Assembly

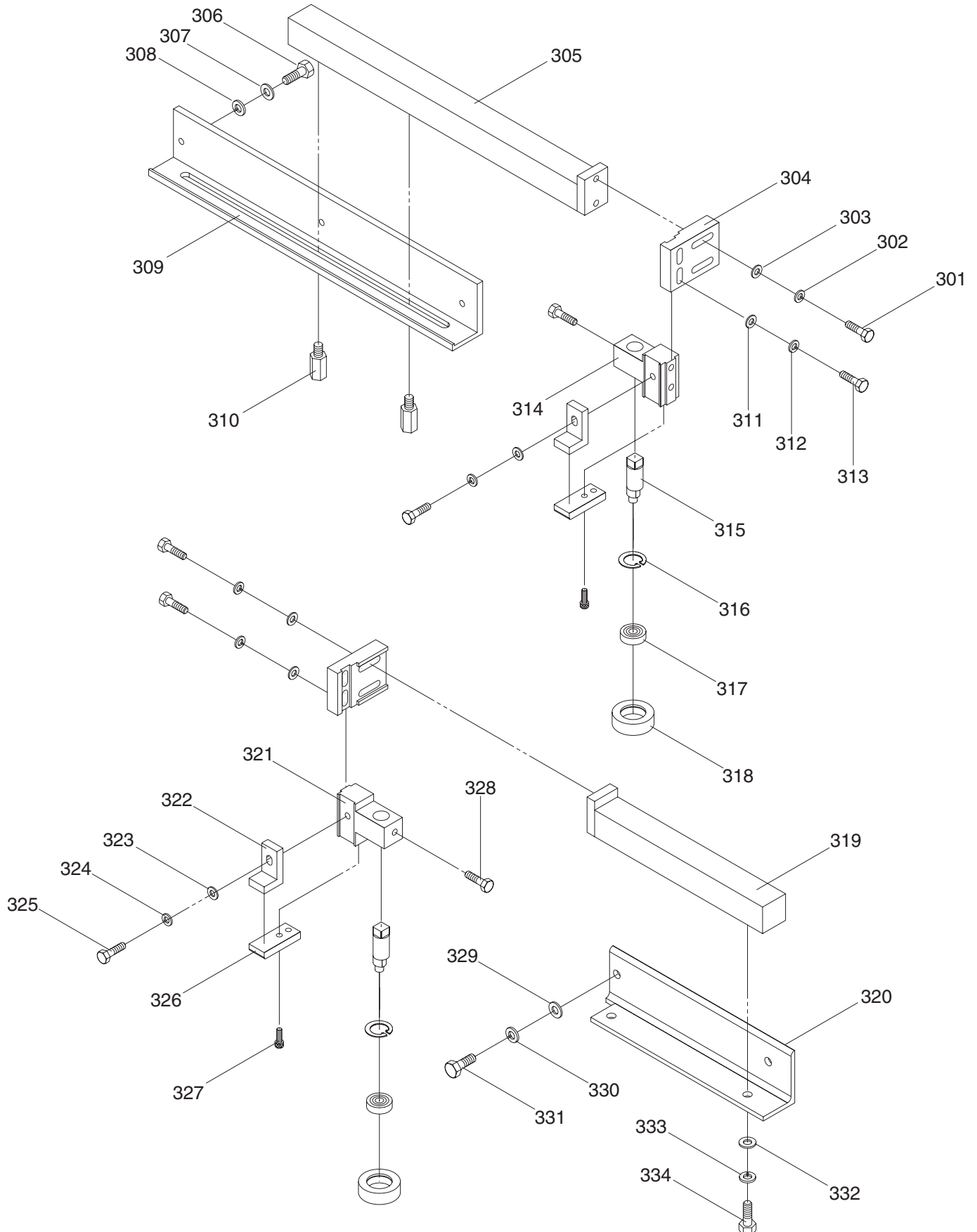


G0504 Elevation Assembly

REF	PART #	DESCRIPTION
201	PB110M	HEX BOLT M16-2 X 25
202	PLW10M	LOCK WASHER 16MM
203	PW08M	FLAT WASHER 16MM
204	P0504204	COLUMN
205	P0504205	CHIP COVER
206	PR50M	INT RETAINING RING 80MM
207	P0504207	OIL SEAL 60 X 80 X 10
208	P0504208	BRASS SLEEVE
209	PSB73M	CAP SCREW M12-1.75 X 50
210	PLW05M	LOCK WASHER 12MM
211	P0504211	ELEVATION HOUSING
212	PSS30M	SET SCREW M10-1.5 X 10
213	P0504213	LOCK RING
214	P0504214	LIMIT DOG
215	PSB12M	CAP SCREW M8-1.25 X 40
216	P0504216	TIGHTEN RING
217	P0504217	DUST GUARD BELLOW
218	PS65M	PHLP HD SCR M4-.8 X 40
219	P0504219	LIMIT SWITCH AV8104
220	P0504220	LIMIT BRACKET
221	PSB02M	CAP SCREW M6-1 X 20
222	PLW03M	LOCK WASHER 6MM
223	PW03M	FLAT WASHER 6MM
224	P0504224	SENSOR COVER
225	P0504225	INDEX RING
226	PSS01M	SET SCREW M6-1.0 X 10
227	PK74M	KEY 6 X 6 X 35
228	PSS64M	SET SCREW M6-1 X 15
229	PK11M	KEY 6 X 6 X 40

REF	PART #	DESCRIPTION
230	PW01M	FLAT WASHER 8MM
231	PLW04M	LOCK WASHER 8MM
232	PSB12M	CAP SCREW M8-1.25 X 40
233	PSS01M	SET SCREW M6-1.0 X 10
234	PSB14M	CAP SCREW M8-1.25 X 20
235	P0504235	GEAR BOX & MOTOR SV-A10
236	PK12M	KEY 5 X 5 X 30
237	PSB14M	CAP SCREW M8-1.25 X 20
238	PLW04M	LOCK WASHER 8MM
239	PW01M	FLAT WASHER 8MM
240	P0504240	FLANGE
241	P0504241	SHAFT COUPLING
242	P0504242	GEAR BOX A
243	P0504243	SHAFT COUPLING
244	P0504244	CONNECT ROD
245	P0504245	GEAR BOX B
246	PW03M	FLAT WASHER 6MM
247	PLW03M	LOCK WASHER 6MM
248	PSB02M	CAP SCREW M6-1 X 20
249	PSB99M	CAP SCREW M3-.5 X 30
250	P0504250	SENSOR QL-1805NB
251	P0504251	SENSOR BRACKET
252	PSB02M	CAP SCREW M6-1 X 20
253	PLW03M	LOCK WASHER 6MM
254	PW03M	FLAT WASHER 6MM
255	PW07M	FLAT WASHER 3MM
256	PLW11M	LOCK WASHER 3MM
257	PN07M	HEX NUT M3-0.5

G0504 Blade Guide Assembly

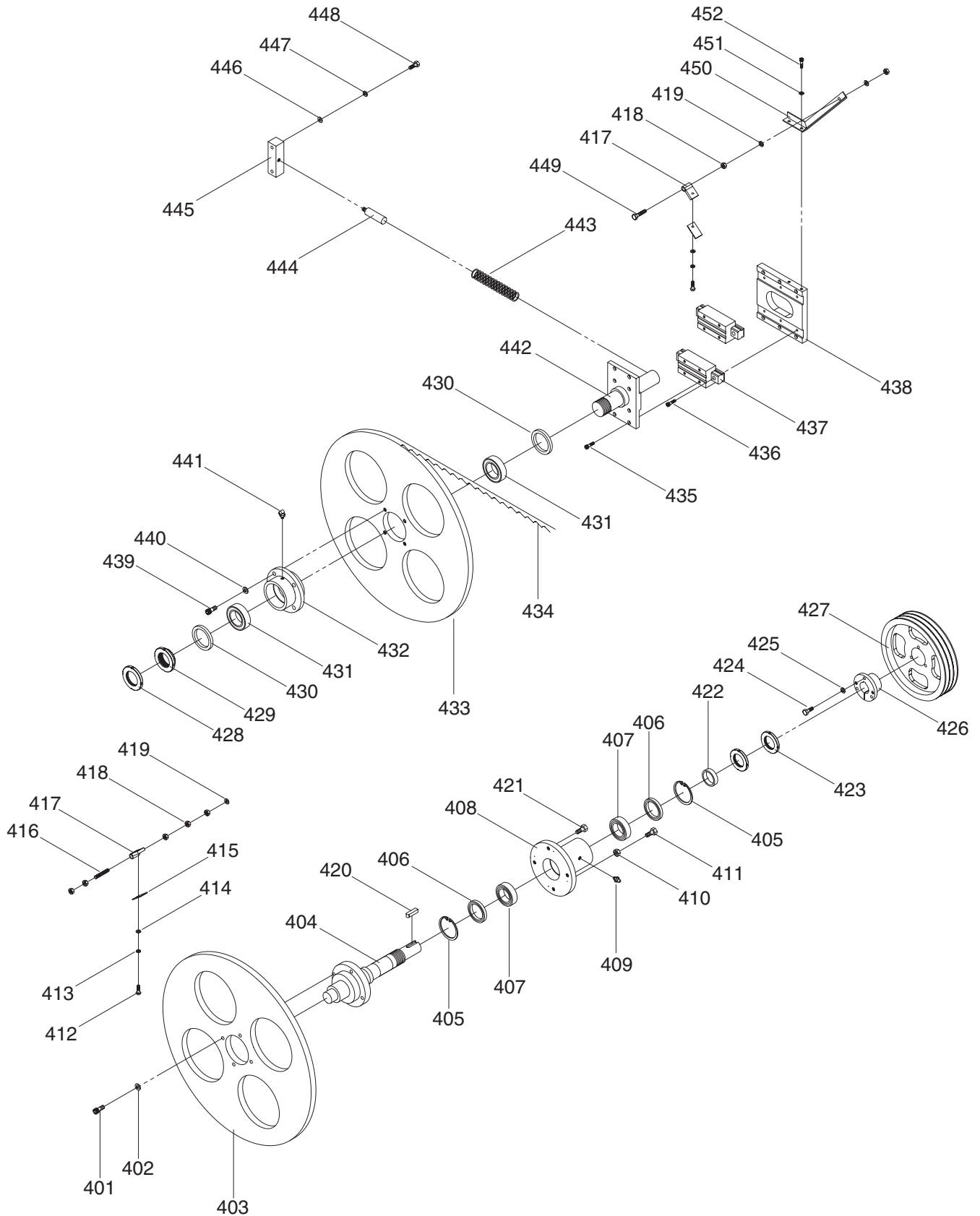


G0504 Blade Guide Assembly

REF	PART #	DESCRIPTION
301	PB15M	HEX BOLT M8-1.25 X 40
302	PLW04M	LOCK WASHER 8MM
303	PW01M	FLAT WASHER 8MM
304	P0504304	ADJUSTMENT BRACKET
305	P0504305	GUIDE POST
306	PB74M	HEX BOLT M10-1.5 X 20
307	PLW06M	LOCK WASHER 10MM
308	PW04M	FLAT WASHER 10MM
309	P0504309	POST BRACKET
310	P0504310	HEX LOCK BOLT
311	PW01M	FLAT WASHER 8MM
312	PLW04M	LOCK WASHER 8MM
313	PB26M	HEX BOLT M8-1.25 X 30
314	P0504314	GUIDE POST BASE
315	P0504315	ECCENTRIC SHAFT
316	PR35M	INT RETAINING RING 30MM
317	P6200	BALL BEARING 6200

REF	PART #	DESCRIPTION
318	P0504318	SUPPORT ROLLER
319	P0504319	GUIDE POST
320	P0504320	POST BRACKET
321	P0504321	GUIDE POST BASE
322	P0504322	UPPER GUIDE
323	PW01M	FLAT WASHER 8MM
324	PLW04M	LOCK WASHER 8MM
325	PB09M	HEX BOLT M8-1.25 X 20
326	P0504326	LOWER GUIDE
327	PSB02M	CAP SCREW M6-1 X 20
328	PB09M	HEX BOLT M8-1.25 X 20
329	PW04M	FLAT WASHER 10MM
330	PLW06M	LOCK WASHER 10MM
331	PB40M	HEX BOLT M10-1.5 X 15
332	PW04M	FLAT WASHER 10MM
333	PLW06M	LOCK WASHER 10MM
334	PB74M	HEX BOLT M10-1.5 X 20

G0504 Blade Wheel Assembly

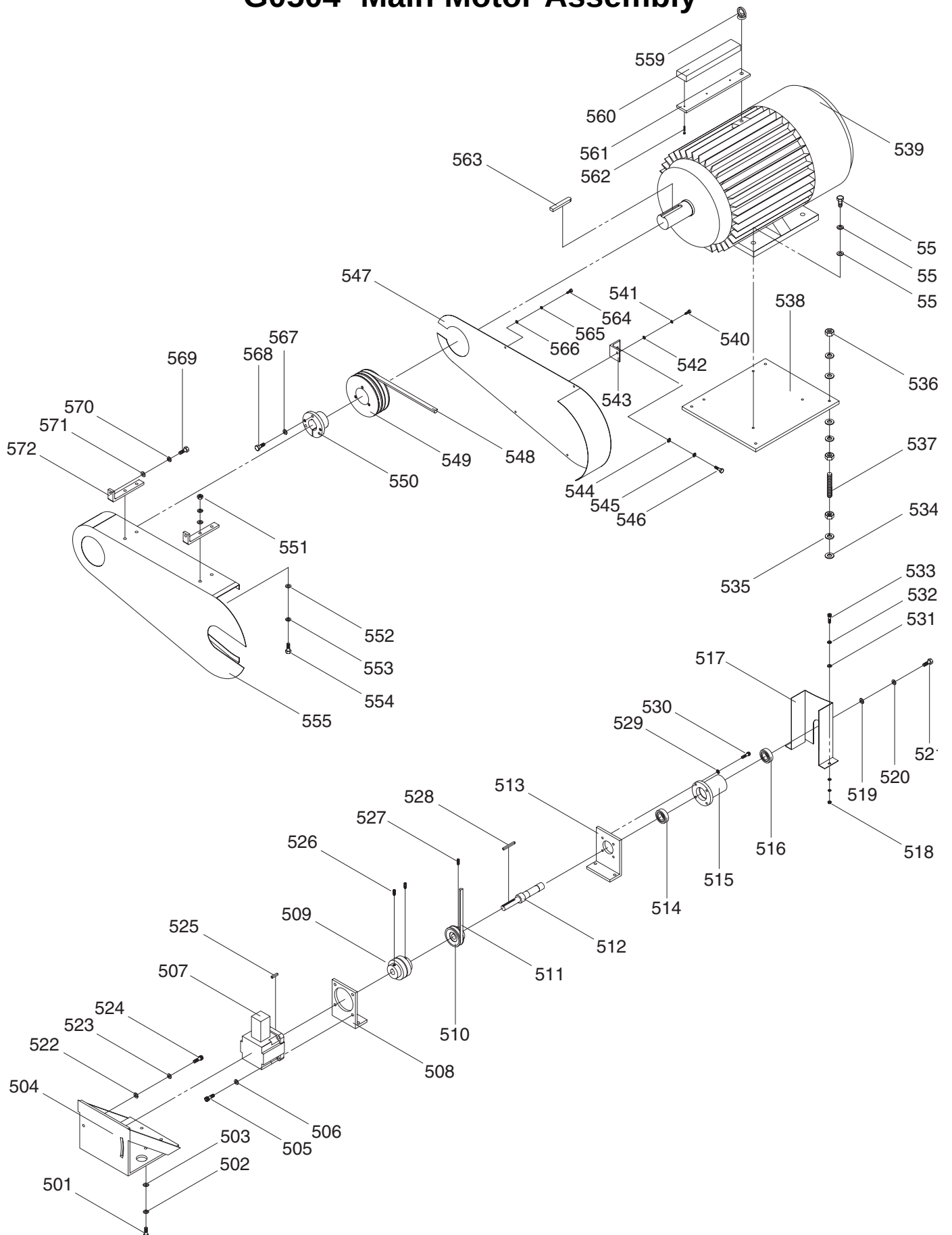


G0504 Blade Wheel Assembly

REF	PART #	DESCRIPTION
401	PSB73M	CAP SCREW M12-1.75 X 50
402	PLW05M	LOCK WASHER 12MM
403	P0504403	DRIVER WHEEL
404	P0504404	DRIVER SHAFT
405	PR50M	INT RETAINING RING 80MM
406	P0504207	OIL SEAL 60 X 80 X 10
407	P32010	BEARING 32010
408	P0504408	BEARING HOUSING
409	PZERK2	GREASE FITTING PT 1/8
410	PN09M	HEX NUT M12-1.75
411	PB101M	HEX BOLT M12-1.75 X 40
412	PSB52M	CAP SCREW M8-1.25 X 10
413	PLW04M	LOCK WASHER 8MM
414	PW01M	FLAT WASHER 8MM
415	P0504415	CLEANER PAD
416	PS66M	PHLP SCREW M10-1.5 X 150
417	P0504417	CLEANER BASE
418	PN02M	HEX NUT M10-1.5
419	PLW06M	LOCK WASHER 10MM
420	PK75M	KEY 12 X 10 X 50
421	PB101M	HEX BOLT M12-1.75 X 40
422	P0504422	SPACER
423	PLN06M	LOCK NUT M50-1.5
424	PB01M	HEX BOLT M10-1.5 X 30
425	PLW06M	LOCK WASHER 10MM
426	P0504426	LOCKING SLEEVE

REF	PART #	DESCRIPTION
427	P0504427	DRIVE PULLEY
428	P0504428	LOCK RING
429	P0504429	LOCK RING
430	P0504430	SEAL 70 X 90 X 10
431	P32011	BEARING 32011
432	P0504432	BEARING HOUSING
433	P0504433	LEFT SAW WHEEL
434	P0504434	SAW BLADE $\frac{3}{4}$ X 180 X 0.035
435	PSB100M	CAP SCREW M8-1.25 X 15
436	PSB13M	CAP SCREW M8-1.25 X 30
437	P0504437	LINER WAY LGH35H
438	P0504438	LINER GUIDE
439	PSB92M	CAP SCREW M12-1.75 X 40
440	PLW05M	LOCK WASHER 12MM
441	PZERK2	GREASE FITTING PT 1/8
442	P0504442	LEFT SAW WHEEL SHAFT
443	P0504443	SPRING
444	P0504444	SPRING ROD
445	P0504445	SPRING SEAT
446	PW04M	FLAT WASHER 10MM
447	PLW06M	LOCK WASHER 10MM
448	PB73M	HEX BOLT M10-1.5 X 50
449	PB13M	HEX BOLT M10-1.5 X 80
450	P0504450	BRACKET
451	PLW04M	LOCK WASHER 8MM
452	PSB100M	CAP SCREW M8-1.25 X 15

G0504 Main Motor Assembly

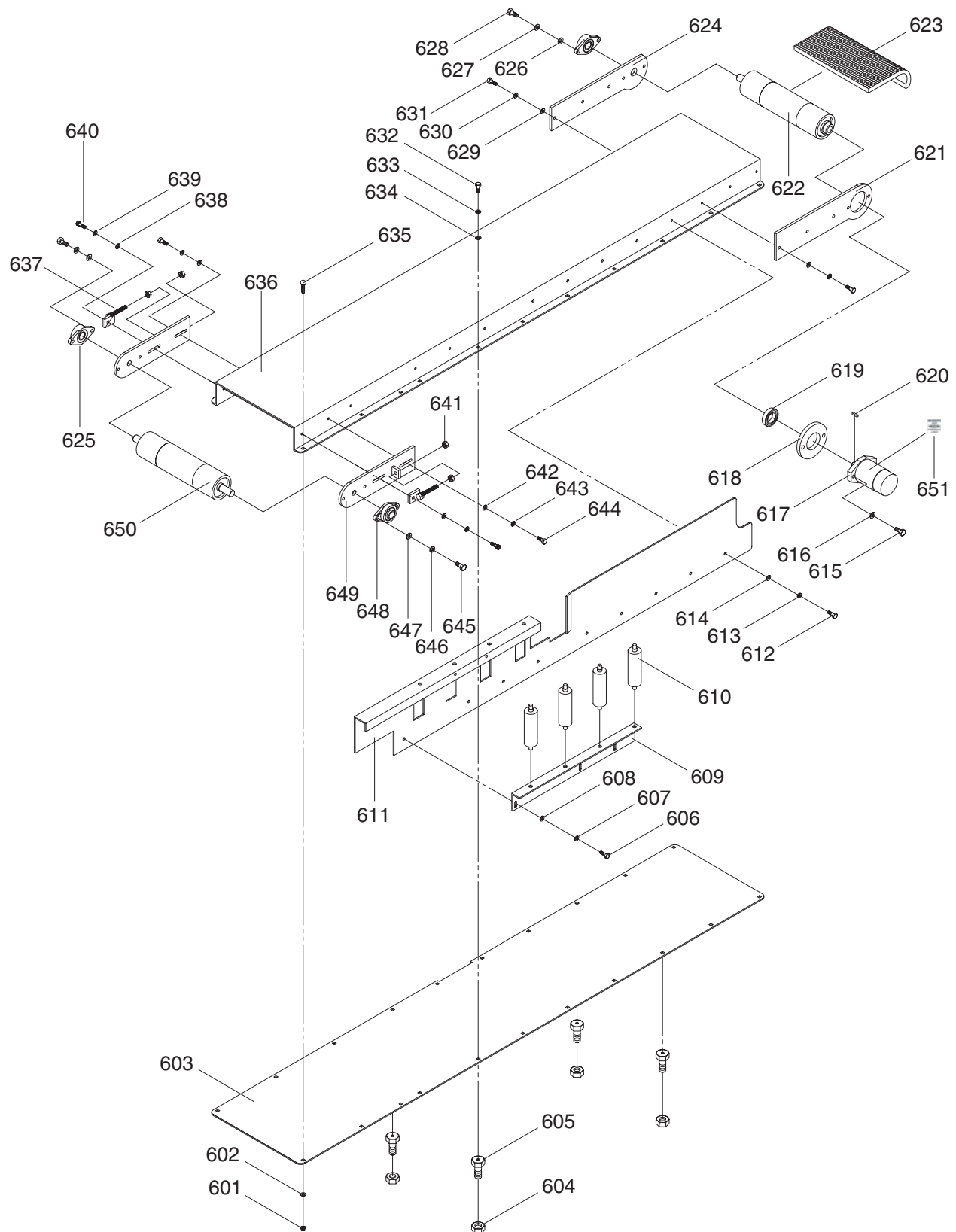


G0504 Main Motor Assembly

REF	PART #	DESCRIPTION
501	PSB61M	CAP SCREW M10-1.5 X 20
502	PLW06M	LOCK WASHER 10MM
503	PW04M	FLAT WASHER 10MM
504	P0504504	PUMP SEAT
505	PSB72M	CAP SCREW M10-1.5 X 30
506	PLW06M	LOCK WASHER 10MM
507	P0504507	OIL PUMP VHIF-40
508	P0504508	PUMP BRACKET
509	P0504509	CONNECTOR
510	P0504510	PUMP PULLEY
511	PVA33	V-BELT A-33
512	P0504512	SHAFT
513	P0504513	PULLEY BRACKET
514	P6205	BALL BEARING 6205
515	P0504515	PULLEY COVER
516	P6205	BALL BEARING 6205
517	P0504517	PULLEY COVER
518	PN01M	HEX NUT M6-1.0
519	PW04M	FLAT WASHER 10MM
520	PLW06M	LOCK WASHER 10MM
521	PB40M	HEX BOLT M10-1.5 X 15
522	PW04M	FLAT WASHER 10MM
523	PLW06M	LOCK WASHER 10MM
524	PSB64M	CAP SCREW M10-1.5 X 25
525	PK42M	KEY 6 X 6 X 30
526	PSS16M	SET SCREW M8-1.25 X 10
527	PSS16M	SET SCREW M8-1.25 X 10
528	PK76M	KEY 6 X 6 X 60
529	PLW04M	LOCK WASHER 8MM
530	PSB14M	CAP SCREW M8-1.25 X 20
531	PW03M	FLAT WASHER 6MM
532	PLW03M	LOCK WASHER 6MM
533	PSB28M	CAP SCREW M6-1.0 X 15
534	PW08M	FLAT WASHER 16MM
535	PLW10M	LOCK WASHER 16MM
536	PN13M	HEX NUT M16-2.0

REF	PART #	DESCRIPTION
537	PS67M	PHLP HD SCREW M16-2 X 20
538	P0504538	MOTOR PLATE
539	P0504539	MOTOR 25HP X 4P
540	PB08M	HEX BOLT M6-1 X 20
541	PLW03M	LOCK WASHER 6MM
542	PW03M	FLAT WASHER 6MM
543	P0504543	L BRACKET
544	PW03M	FLAT WASHER 6MM
545	PLW03M	LOCK WASHER 6MM
546	PB08M	HEX BOLT M6-1 X 20
547	P0504547	PULLEY COVER
548	PVB77	V-BELT B-77 5L770
549	P0504549	MOTOR PULLEY
550	P0504550	LOCKING SLEEVE
551	PN03M	HEX NUT M8-1.25
552	PW01M	FLAT WASHER 8MM
553	PLW04M	LOCK WASHER 8MM
554	PB87M	HEX BOLT M8-1.25 X 15
555	P0504555	PULLEY GUARD
556	PW06M	FLAT WASHER 12MM
557	PLW05M	LOCK WASHER 12MM
558	PB27M	HEX BOLT M12-1.75 X 30
559	P0504559	RING BOLT
560	P0504560	RUBBER PAD
561	P0504561	RUBBER SEAT
562	PHTEK2	TAP SCREW #8 X 1
563	PK77M	KEY 12 X 8 X 80
564	PB18M	HEX BOLT M6-1 X 15
565	PLW03M	LOCK WASHER 6MM
566	PW03M	FLAT WASHER 6MM
567	PLW06M	LOCK WASHER 10MM
568	PB01M	HEX BOLT M10-1.5 X 30
569	PB09M	HEX BOLT M8-1.25 X 20
570	PLW04M	LOCK WASHER 8MM
571	PW01M	FLAT WASHER 8MM
572	P0504572	GUARD BRACKET

G0504 Main Conveyor Assembly

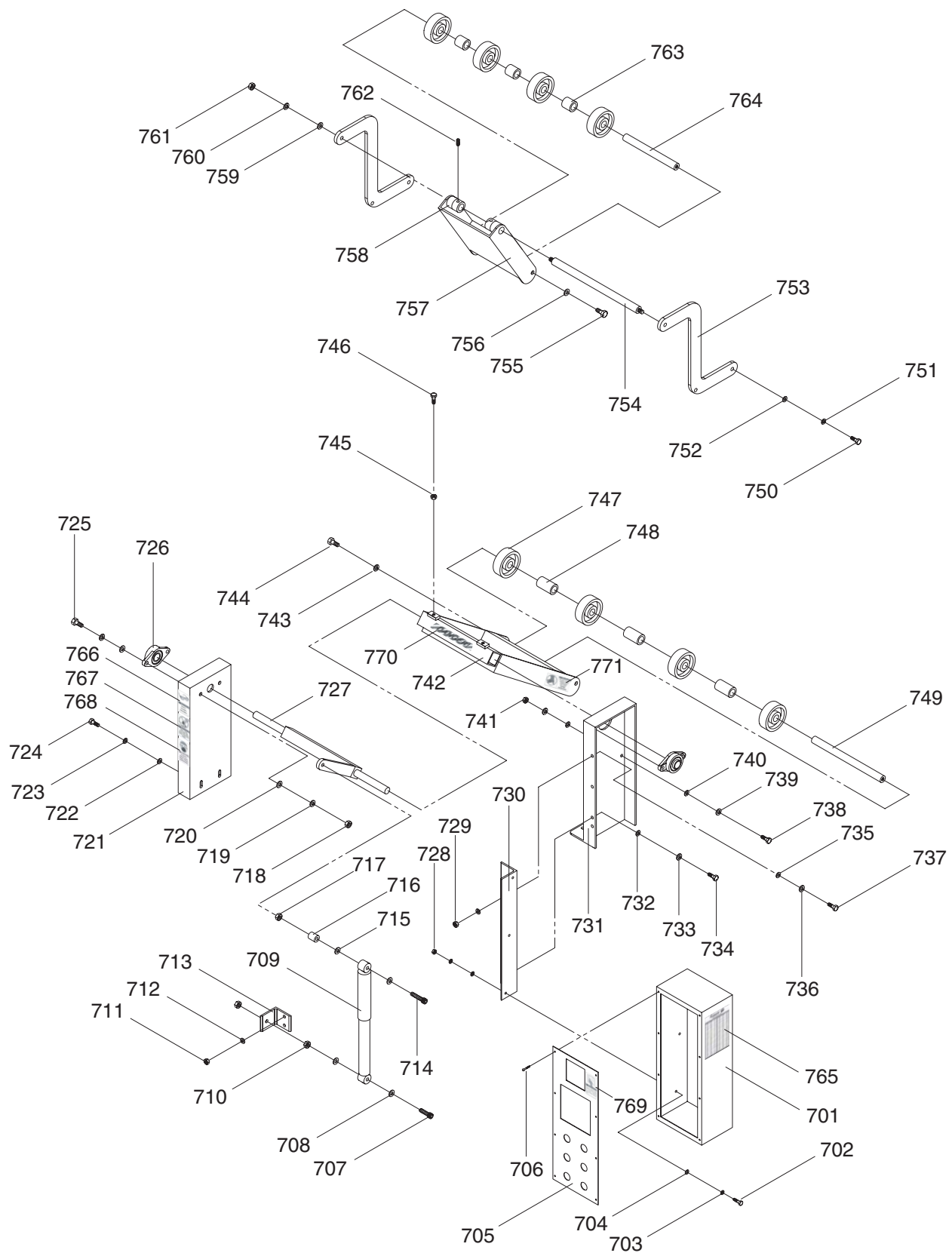


G0504 Main Conveyor Assembly

REF	PART #	DESCRIPTION
601	PN02M	HEX NUT M10-1.5
602	PW04M	FLAT WASHER 10MM
603	P0504603	CONVEYOR LOWER PLATE
604	PN33M	HEX NUT M24-2
605	P0504605	ADJUSTABLE BOLT M24 X 90
606	PB01M	HEX BOLT M10-1.5 X 30
607	PLW06M	LOCK WASHER 10MM
608	PW04M	FLAT WASHER 10MM
609	P0504609	ROLLER SEAT
610	P0504610	ROLLER
611	P0504611	ROLLER PLATE
612	PB01M	HEX BOLT M10-1.5 X 30
613	PLW06M	LOCK WASHER 10MM
614	PW04M	FLAT WASHER 10MM
615	PB33M	HEX BOLT M12-1.75 X 50
616	PLW05M	LOCK WASHER 12MM
617	P0504617	3/8 HYD MOTOR OMP 80CC
618	P0504618	OIL PUMP FLANGE
619	P6008	BALL BEARING 6008
620	PK42M	KEY 6 X 6 X 30
621	P0504621	REAR ROLLER BRACKET R
622	P0504622	REAR ROLLER
623	P0504623	CONVEYOR BELT
624	P0504624	REAR ROLLER BRACKET L
625	P0504625	FLANGE BEARING UCFL205
626	PW06M	FLAT WASHER 12MM

REF	PART #	DESCRIPTION
627	PLW05M	LOCK WASHER 12MM
628	PB102M	HEX BOLT M12-1.75 X 25
629	PW04M	FLAT WASHER 10MM
630	PLW06M	LOCK WASHER 10MM
631	PB01M	HEX BOLT M10-1.5 X 30
632	PB01M	HEX BOLT M10-1.5 X 30
633	PLW06M	LOCK WASHER 10MM
634	PW04M	FLAT WASHER 10MM
635	PCB09M	CARRIAGE BOLT M10-1.5 X 25
636	P0504636	CONVEYOR PLATEN
637	P0504637	ADJUSTABLE SCREW
638	PW04M	FLAT WASHER 10MM
639	PLW06M	LOCK WASHER 10MM
640	PSB72M	CAP SCREW M10-1.5 X 30
641	PN02M	HEX NUT M10-1.5
642	PW04M	FLAT WASHER 10MM
643	PLW06M	LOCK WASHER 10MM
644	PB32M	HEX BOLT M10-1.5 X 25
645	PB102M	HEX BOLT M12-1.75 X 25
646	PLW05M	LOCK WASHER 12MM
647	PW06M	FLAT WASHER 12MM
648	P0504625	FLANGE BEARING UCFL205
649	P0504649	ROLLER BRACKET
650	P0504650	FRONT ROLLER
651	P0504651	HIGH PRESSURE HYD LABEL

G0504 Pressure Roller and Control Panel Assembly

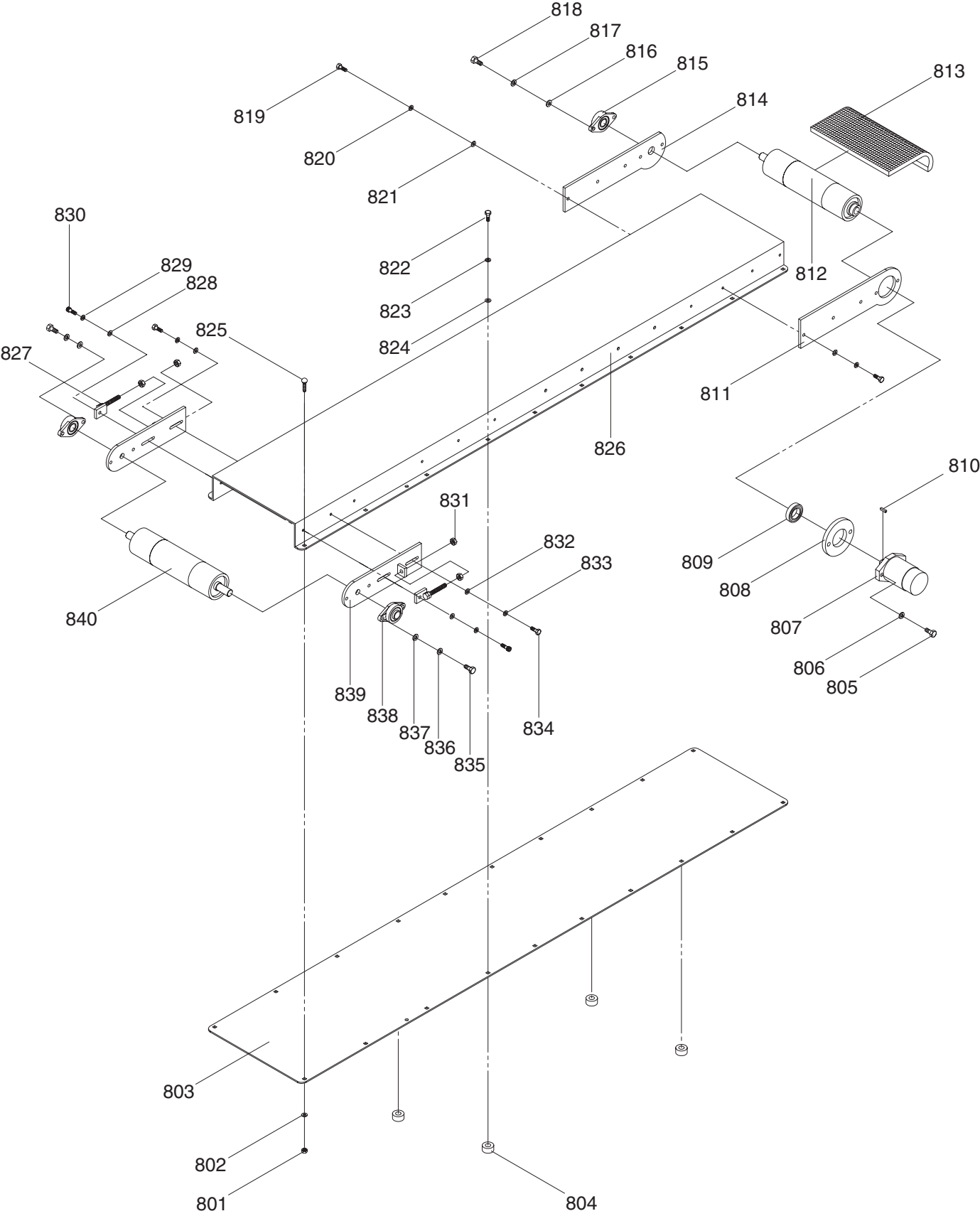


G0504 Pressure Roller and Control Panel Assembly

REF	PART #	DESCRIPTION
701	P0504701	CONTROL BOX
702	PB09M	HEX BOLT M8-1.25 X 20
703	PLW04M	LOCK WASHER 8MM
704	PW01M	FLAT WASHER 8MM
705	P0504705	CONTROL PANEL
706	PS38M	PHLP HD SCR M4-.7 X 10
707	PSB63M	CAP SCREW M12-1.75 X 60
708	PW06M	FLAT WASHER 12MM
709	P0504709	SHOCK ABSORBER
710	PN09M	HEX NUT M12-1.75
711	PN02M	HEX NUT M10-1.5
712	PLW06M	LOCK WASHER 10MM
713	P0504713	CUSHION LOWER BRACKET
714	PSB101M	CAP SCREW M12-1.75 X 90
715	PW06M	FLAT WASHER 12MM
716	P0504716	COLLAR
717	PN09M	HEX NUT M12-1.75
718	PN09M	HEX NUT M12-1.75
719	PLW05M	LOCK WASHER 12MM
720	PW06M	FLAT WASHER 12MM
721	P0504721	PRESS ROLLER SUPPORT
722	PW04M	FLAT WASHER 10MM
723	PLW06M	LOCK WASHER 10MM
724	PB32M	HEX BOLT M10-1.5 X 25
725	PB101M	HEX BOLT M12-1.75 X 40
726	P0504625	FLANGE BEARING UCFL205
727	P0504727	UPPER SHAFT
728	PN03M	HEX NUT M8-1.25
729	PN02M	HEX NUT M10-1.5
730	P0504730	PANEL BRACKET
731	P0504731	PRESS ROLLER SUPPORT
732	PW04M	FLAT WASHER 10MM
733	PLW06M	LOCK WASHER 10MM
734	PB01M	HEX BOLT M10-1.5 X 30
735	PW04M	FLAT WASHER 10MM
736	PLW06M	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
737	PB74M	HEX BOLT M10-1.5 X 20
738	PB01M	HEX BOLT M10-1.5 X 30
739	PLW06M	LOCK WASHER 10MM
740	PW04M	FLAT WASHER 10MM
741	PN02M	HEX NUT M10-1.5
742	P0504742	FRONT PRESSURE PLATE
743	PLW05M	LOCK WASHER 12MM
744	PB49M	HEX BOLT M12-1.75 X 20
745	PN02M	HEX NUT M10-1.5
746	PB31M	HEX BOLT M10-1.5 X 40
747	P0504747	PRESSURE ROLLER WHEEL
748	P0504748	COLLAR
749	P0504749	ROLLER SHAFT
750	PB01M	HEX BOLT M10-1.5 X 30
751	PLW06M	LOCK WASHER 10MM
752	PW04M	FLAT WASHER 10MM
753	P0504753	REAR ROLLER BRACKET
754	P0504754	REAR UPPER SHAFT
755	PB49M	HEX BOLT M12-1.75 X 20
756	PLW05M	LOCK WASHER 12MM
757	P0504757	REAR PRESSURE PLATE
758	P0504758	COLLAR
759	PW06M	FLAT WASHER 12MM
760	PLW05M	LOCK WASHER 12MM
761	PN09M	HEX NUT M12-1.75
762	PSS30M	SET SCREW M10-1.5 X 10
763	P0504763	COLLAR
764	P0504764	ROLLER SHAFT
765	PLABEL-27	CONVERSION CHART LABEL
766	PLABEL-11	SAFETY GLASSES LABEL
767	PLABEL-31	CONVEYOR/CLOTHING LABEL
768	PLABEL-32	DUST MASK LABEL
769	PLABEL-12	READ MANUAL LABEL
770	P0504770	DANGER LABEL
771	P0504771	HAND NEAR ROLLERS LABEL

G0504 Return Conveyor Assembly

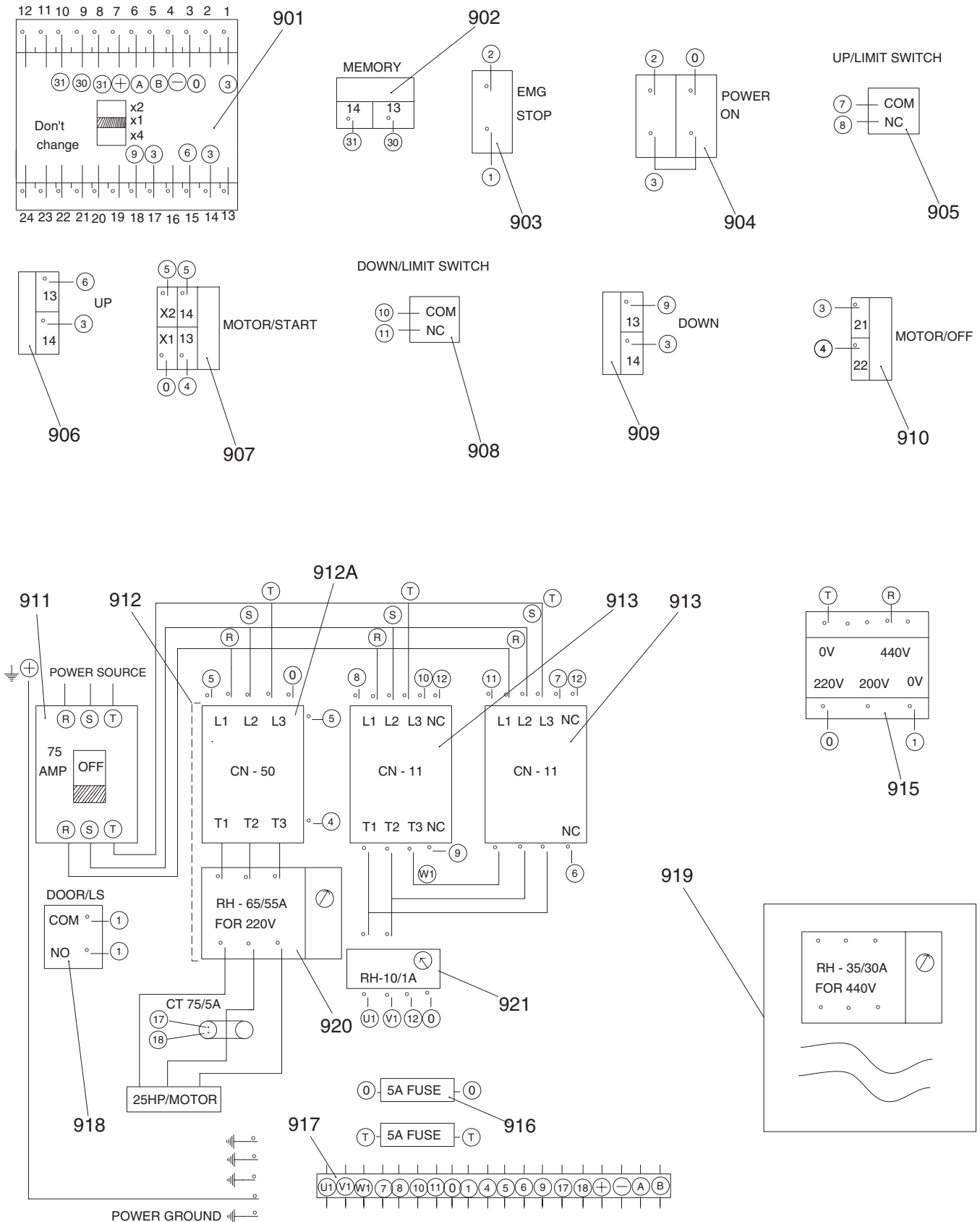


G0504 Return Conveyor Assembly

REF	PART #	DESCRIPTION
801	PN02M	HEX NUT M10-1.5
802	PW04M	FLAT WASHER 10MM
803	P0504803	CONVEYOR LOWER PLATE
804	P0504804	BUSHING
805	PB33M	HEX BOLT M12-1.75 X 50
806	PLW05M	LOCK WASHER 12MM
807	P0504617	3/8 HYD MOTOR OMP 80CC
808	P0504618	OIL PUMP FLANGE
809	P6008	BALL BEARING 6008
810	PK42M	KEY 6 X 6 X 30
811	P0504621	REAR ROLLER BRACKET-R
812	P0504812	REAR ROLLER
813	P0504813	CONVEYOR BELT
814	P0504624	REAR ROLLER BRACKET-L
815	P0504625	FLANGE BEARING UCFL205
816	PW06M	FLAT WASHER 12MM
817	PLW05M	LOCK WASHER 12MM
818	PB102M	HEX BOLT M12-1.75 X 25
819	PB01M	HEX BOLT M10-1.5 X 30
820	PLW06M	LOCK WASHER 10MM

REF	PART #	DESCRIPTION
821	PW04M	FLAT WASHER 10MM
822	PB01M	HEX BOLT M10-1.5 X 30
823	PLW06M	LOCK WASHER 10MM
824	PW04M	FLAT WASHER 10MM
825	PCB09M	CARRIAGE BOLT M10-1.25 X 25
826	P0504826	CONVEYOR TABLE
827	P0504827	ADJUSTMENT BOLT
828	PW04M	FLAT WASHER 10MM
829	PLW06M	LOCK WASHER 10MM
830	PSB72M	CAP SCREW M10-1.5 X 30
831	PN02M	HEX NUT M10-1.5
832	PW04M	FLAT WASHER 10MM
833	PLW06M	LOCK WASHER 10MM
834	PB32M	HEX BOLT M10-1.5 X 25
835	PB102M	HEX BOLT M12-1.75 X 25
836	PLW05M	LOCK WASHER 12MM
837	PW06M	FLAT WASHER 12MM
838	P0504625	FLANGE BEARING UCFL205
839	P0504649	FRONT ROLLER BRACKET
840	P0504840	FRONT ROLLER

G0504 Electrical Components

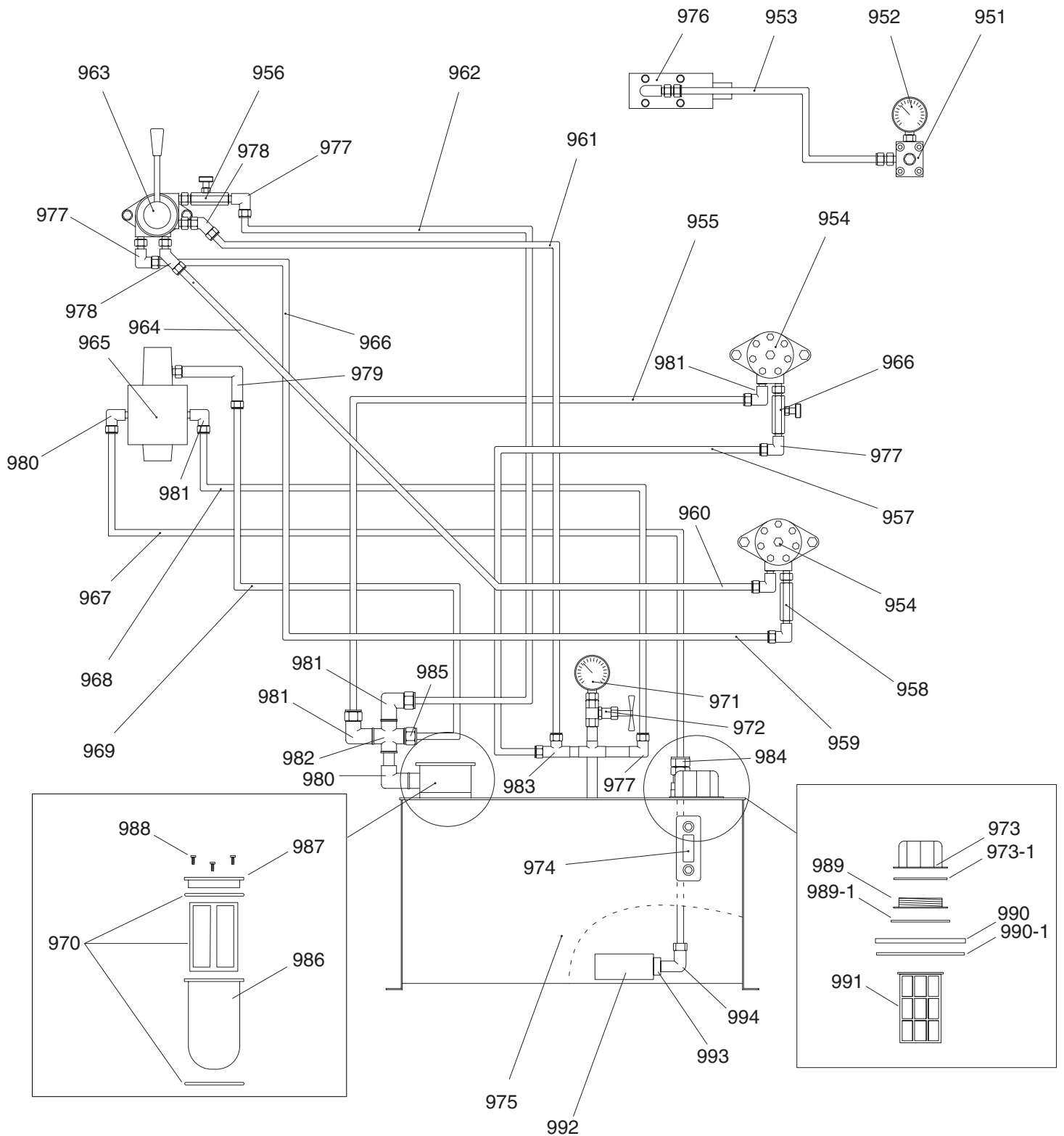


G0504 Electrical Components

REF	PART #	DESCRIPTION
901	P0504901	DIGITAL DISPLAY FPC-525/IN.
902	P0504902	MEMORY BUTTON
903	P0504903	EMG BUTTON DIA.30 1B
904	P0504904	ON BUTTON DIA.30 1A
905	P0504905	UP/LIMIT SWITCH DIA.30
906	P0504906	UP BUTTON DIA.30
907	P0504907	MOTOR START/GREEN DIA.30
908	P0504908	DOWN/LIMIT SWITCH DIA.30
909	P0504909	DOWN BUTTON DIA.30
910	P0504910	MOTOR STOP/RED DIA.30
911	P0504911	SWITCH NFB 3-PH 75A

REF	PART #	DESCRIPTION
912	P0504912	MAG START HKO-50/10HP/30A
912A	P0504912A	CONTACTOR CN-50
913	P0504913	CONTACTOR CN-11
915	P0504915	TRANSFORMER 200VA
916	P0504916	FUSE TERMINAL
917	P0504917	ELECTRIC SET 10A/1P
918	P0504918	DOOR/MICRO SWITCH
919	P0504919	440V CONVERSION KIT
920	P0504920	220V OVR-RELAY RH - 65/55A
921	P0504921	OV-RELAY RH-10/1A

G0504 Hydraulic System Components



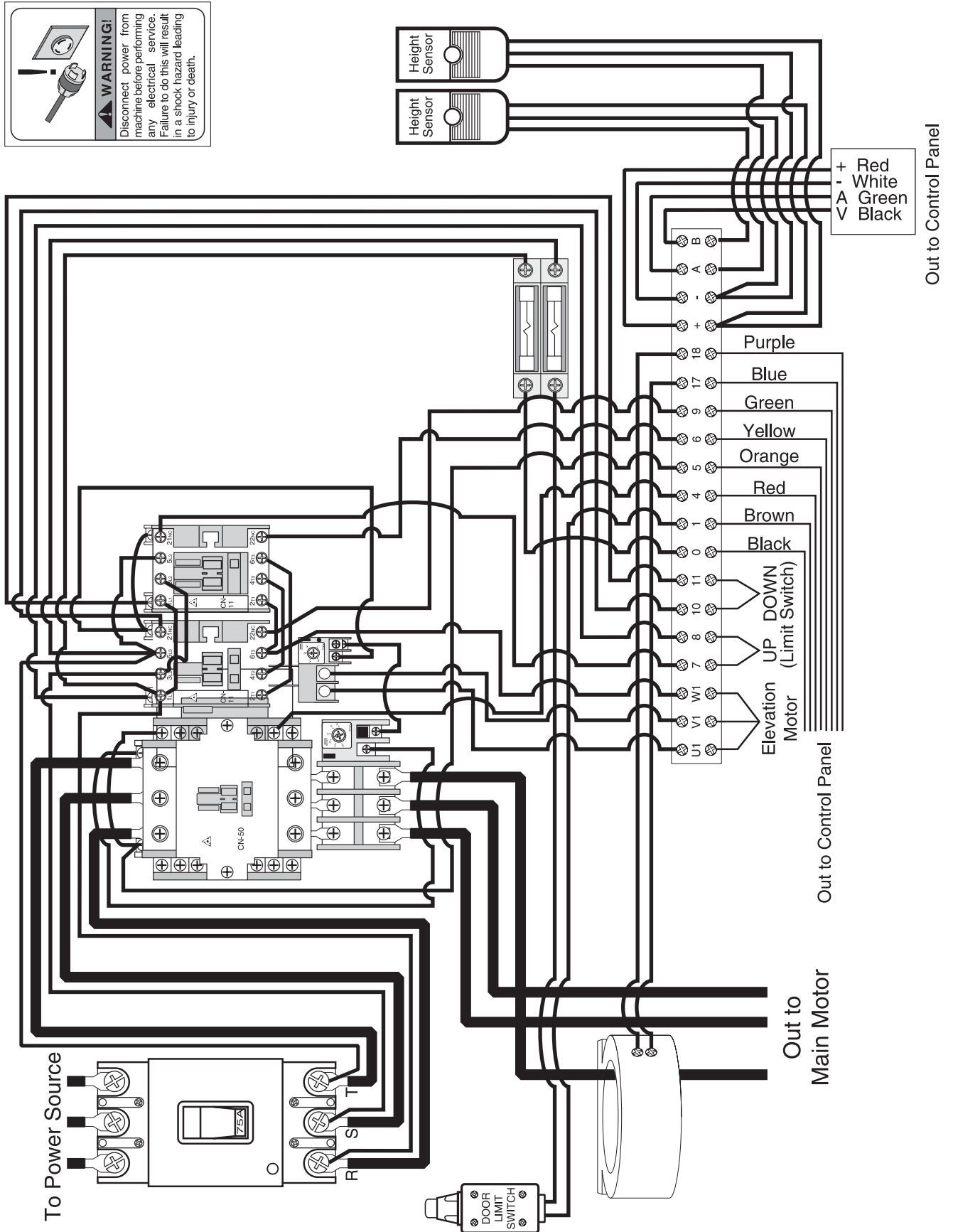
G0504 Hydraulic System Components

REF	PART #	DESCRIPTION
951	P0504951	HYDRAULIC AIR CYLINDER
952	P0504952	PRESSURE GAUGE
953	P0504953	3/8 HYDRAULIC HOSE
954	P0504807	3/8 HYD MOTOR OMP 80CC
955	P0504955	3/8 HYDRAULIC HOSE
956	P0504956	SPEED CONTROL VALVE 3/8
957	P0504957	3/8 HYDRAULIC HOSE
958	P0504958	STOP HYDRAULIC OIL VALVE
959	P0504959	HYDRAULIC HOSE
960	P0504960	3/8 HYDRAULIC HOSE
961	P0504961	3/8 HYDRAULIC HOSE
962	P0504962	3/8 HYDRAULIC HOSE
963	P0504963	3/8 HYDRAULIC VALVE
964	P0504964	3/8 HYDRAULIC HOSE
965	P0504965	HYDRAULIC PUMP VP40
966	P0504966	HYDRAULIC HOSE
967	P0504967	1/2 HYDRAULIC HOSE
968	P0504968	3/8 HYDRAULIC HOSE
969	P0504969	3/8 HYDRAULIC HOSE
970	P0504970	FILTER KIT (FILTER + ORINGS)
971	P0504971	PRESSURE GAUGE
972	P0504972	VALVE
973	P0504973	LID
973-1	P0504973-1	LID GASKET

REF	PART #	DESCRIPTION
974	P0504974	OIL LEVEL
975	P0504975	OIL BOX 80L
976	P0504976	HYDRAULIC JACK
977	P0504977	MALE ELBOW 3/8T X 3/8H 90°
978	P0504978	MALE ELBOW 3/8T X 3/8H 45°
979	P0504979	MALE ELBOW 1/4T X 3/8H
980	P0504980	MALE ELBOW 3/4T X 1/2H 90°
981	P0504981	MALE ELBOW 1/2T X 3/8H 90°
982	P0504982	FEMALE 4-WAY 1/2T X 4
983	P0504983	MALE 3-WAY 3/8T X 3/8H X 3/8H
984	P0504984	MALE ELBOW 3/4T X 1/2H
985	P0504985	MALE ELBOW 1/2T X 3/8H
986	P0504986	FILTER CANISTER
987	P0504987	CAP
988	PFB06M	FLANGE BOLT M6-1.0 X 20
989	P0504989	FILLER CAP THREAD PIECE
989-1	P0504989-1	THREAD PIECE GASKET
990	P0504990	SQUARE PLATE
990-1	P0504990-1	SQUARE PLATE GASKET
991	P0504991	PLASTIC FILL SCREEN
992	P0504992	TANK PICKUP SCREEN
993	P0504993	TANK SCREEN NIPPLE
994	P0504994	ELBOW 1-1/4 X 3/4

Troubleshooting

Symptom	Possible Cause	Possible Solution
Motor will not start.	1. Low voltage. 2. Open circuit in motor or loose connections.	1. Check power line for proper voltage. 2. Inspect all lead connections on motor for loose or open connections.
Motor will not start; fuses or circuit breakers blow.	1. Short circuit in line cord or plug. 2. Short circuit in motor or loose connections. 3. Circuit or motor overloaded.	1. Repair or replace cord or plug for damaged insulation and shorted wires. 2. Repair or replace all connections on motor for loose or shorted terminals or worn insulation. 3. Reduce amperage load on circuit or motor.
Motor fails to develop full power (power output of motor decreases rapidly with decrease in voltage at motor terminals).	1. Power line overloaded with lights, appliances, and other motors. 2. Undersized wires or circuits too long. 3. General overloading of power company facilities.	1. Reduce load on power line. 2. Increase wire sizes or reduce length of wire. 3. Request a power check from the power company.
Motor overheats.	1. Motor overloaded. 2. Air circulation through the motor restricted.	1. Reduce load on motor. 2. Clean out motor to provide normal air circulation.
Motor stalls (resulting in blown fuses or tripped circuit).	1. Short circuit in motor or loose connections. 2. Low voltage. 3. Incorrect fuses or circuit breakers in power line. 4. Motor overloaded.	1. Repair or replace connections on motor for loose or shorted terminals or worn insulation. 2. Correct the low voltage conditions. 3. Install correct fuses or circuit breakers. 4. Reduce load on motor.
Machine slows when operating.	Applying too much pressure to workpiece.	Feed workpiece slower.
Blade does not run evenly on wheels.	1. Blade support bearings set incorrectly. 2. Wheels are not coplanar.	1. Adjust blade support bearings. 2. Call Grizzly Service Department (570) 546-9663.
Blade does not cut evenly.	1. Blade is not properly tensioned. 2. Wheels are not coplanar. 3. Tooth set is uneven. 4. Teeth are sharper on one side than the other.	1. Adjust blade tension. 2. Call Grizzly Service Department (570) 546-9663. 3. Replace blade. 4. Replace blade.
Blade slows when cutting. Blade makes a squealing noise, especially on start-up.	1. V-belt loose. 2. V-belt worn out.	1. Tighten V-belt. 2. Replace V-belt.
Ticking sound when the saw is running.	Blade weld contacting guide blocks or support bearing.	Use the Model G2516 Stone to smooth the blade weld.
Hydraulic pump is noisy or hydraulic system operates erratically.	1. Pump is restricted. 2. Filter is clogged. 3. Tank screen is clogged. 4. Damaged hydraulic pump or motor.	1. Inspect and clean breather cap, filter, and filler screen. 2. Perform minor service. See page 33. 3. Perform major service. See page 35. 4. Replace pump or motor. See hydraulic specialist.



Grizzly[®]
Industrial, Inc.

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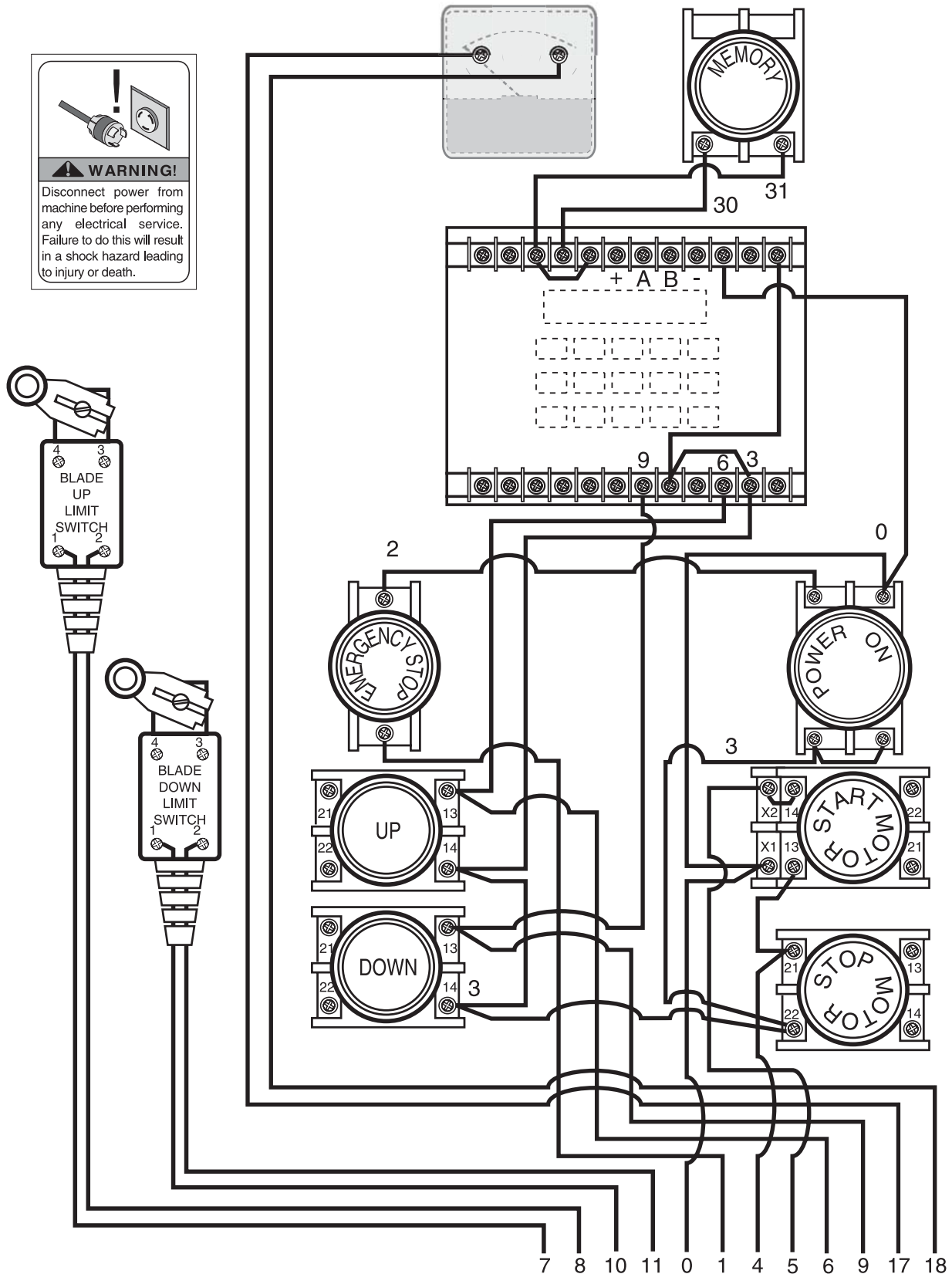
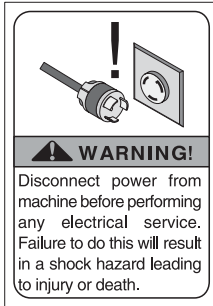




G0504 Wiring Diagram

G0504 16" Horizontal Resaw Bandsaw
Wiring Diagram - Control Panel

Control panel viewed from the back



WARRANTY AND RETURNS

Grizzly Industrial, Inc. warrants every product it sells for a period of **1 year** to the original purchaser from the date of purchase. This warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence, accidents, repairs or alterations or lack of maintenance. This is Grizzly's sole written warranty and any and all warranties that may be implied by law, including any merchantability or fitness, for any particular purpose, are hereby limited to the duration of this written warranty. We do not warrant or represent that the merchandise complies with the provisions of any law or acts unless the manufacturer so warrants. In no event shall Grizzly's liability under this warranty exceed the purchase price paid for the product and any legal actions brought against Grizzly shall be tried in the State of Washington, County of Whatcom.

We shall in no event be liable for death, injuries to persons or property or for incidental, contingent, special, or consequential damages arising from the use of our products.

To take advantage of this warranty, contact us by mail or phone and give us all the details. We will then issue you a "Return Number," which must be clearly posted on the outside as well as the inside of the carton. We will not accept any item back without this number. Proof of purchase must accompany the merchandise.

The manufacturers reserve the right to change specifications at any time because they constantly strive to achieve better quality equipment. We make every effort to ensure that our products meet high quality and durability standards and we hope you never need to use this warranty.

Please feel free to write or call us if you have any questions about the machine or the manual.

Thank you again for your business and continued support. We hope to serve you again soon.

WARRANTY CARD

Name _____
Street _____
City _____ State _____ Zip _____
Phone Number _____ E-Mail _____ FAX _____
MODEL: G0504 16" Resaw Bandsaw Serial # _____ Order _____

The following information is given on a voluntary basis. It will be used for marketing purposes to help us develop better products and services. Of course, all information is strictly confidential.

1. How did you learn about us?
____ Advertisement _____ Friend
____ Catalog _____ Card Deck
____ World Wide Web
____ Other _____
2. Which of the following magazines do you subscribe to.
____ American Woodworker _____ Practical Homeowner
____ Cabinetmaker _____ Shop Notes
____ Family Handyman _____ Today's Homeowner
____ Fine Homebuilding _____ WOOD
____ Fine Woodworking _____ Wooden Boat
____ Home Handyman _____ Woodshop News
____ Journal of Light Construction _____ Woodsmith
____ Old House Journal _____ Woodwork
____ Popular Mechanics _____ Woodworker
____ Popular Science _____ Woodworker's Journal
____ Popular Woodworking _____ Workbench
____ Other _____
3. Which of the following woodworking/remodeling shows do you watch?
____ Backyard America _____ The New Yankee Workshop
____ Home Time _____ This Old House
____ The American Woodworker _____ Woodwright's Shop
____ Other _____
4. What is your annual household income?
____ \$20,000-\$29,999 _____ \$60,000-\$69,999
____ \$30,000-\$39,999 _____ \$70,000-\$79,999
____ \$40,000-\$49,999 _____ \$80,000-\$89,999
____ \$50,000-\$59,999 _____ \$90,000 +
5. What is your age group?
____ 20-29 _____ 50-59
____ 30-39 _____ 60-69
____ 40-49 _____ 70 +
6. How long have you been a woodworker?
____ 0 - 2 Years _____ 8 - 20 Years
____ 2 - 8 Years _____ 20+ Years
7. How would you rank your woodworking skills?
____ Simple _____ Advanced
____ Intermediate _____ Master Craftsman
8. What stationary woodworking tools do you own? Check all that apply.
____ Air Compressor _____ Panel Saw
____ Band Saw _____ Planer
____ Drill Press _____ Power Feeder
____ Drum Sander _____ Radial Arm Saw
____ Dust Collector _____ Shaper
____ Horizontal Boring Machine _____ Spindle Sander
____ Jointer _____ Table Saw
____ Lathe _____ Vacuum Veneer Press
____ Mortiser _____ Wide Belt Sander
9. _____ Other _____
How many of your woodworking machines are Grizzly? _____
10. Which benchtop tools do you own? Check all that apply.
____ 1" x 42" Belt Sander _____ 6" - 8" Grinder
____ 5" - 8" Drill Press _____ Mini Lathe
____ 8" Table Saw _____ 10" - 12" Thickness Planer
____ 8" - 10" Bandsaw _____ Scroll Saw
____ Disc/Belt Sander _____ Spindle/Belt Sander
____ Mini Jointer
____ Other _____
11. How many of the machines checked above are Grizzly? _____
12. Which portable/hand held power tools do you own? Check all that apply.

13. What machines/supplies would you like Grizzly Industrial to carry?

14. What new accessories would you like Grizzly Industrial to carry?
____ Builders Hardware _____ Hand Tools
____ Fasteners _____ Wood Components
____ Other _____
15. What other companies do you purchase your tools and supplies from?

16. Do you think your purchase represents good value?
____ Yes _____ No
17. Would you recommend Grizzly Industrial to a friend?
____ Yes _____ No
18. Would you allow us to use your name as a reference for Grizzly customers in your area? **Note: We never use names more than three times.**
____ Yes _____ No
19. Comments: _____

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